



合隆技術標準指引

HopLun Technical standard direction

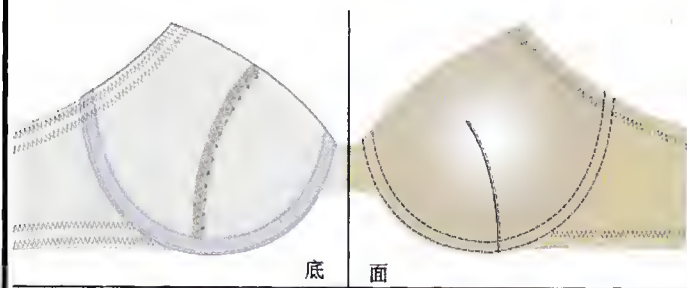
2、紙樣標準類 Pattern Standard

2-1、紙樣製作 Pattern making

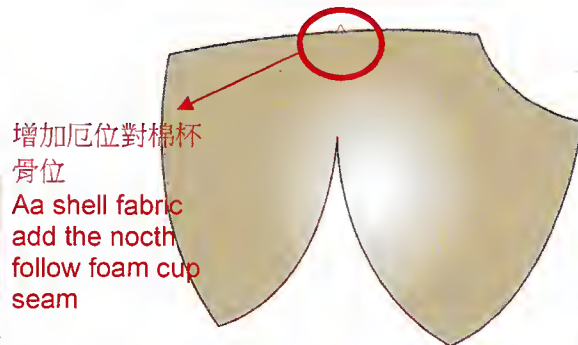
標準概述:	面杯為左右杯的紙樣做法
Standard summarise :	Method of making paper pattern for bras have R/L cup
執行日期:	2011年8月16日
Term of expiration date:	16-Aug-11
跟進人員:	紙樣組長/辦房車間/模杯組
Follow-up staffs:	Pattern team leader / Sample workshop/Mould team

標準說明:
Standard explanation :

- 1.左右杯棉圍款,面杯有杯折骨的,面杯杯邊需加厄位對棉骨位
1.For padded bras,if foam is R/L cup and also have seam on shell, notch will be added at top cup to follow the foam cup seam.



1.1.棉圍 Pad bra



1.2.面布紙樣 Paper pattern of shell

備注說明Remarks:

從即日新單開始.

This method will be adopted for new order from now on.

合隆技術標準指引

HopLun Technical standard direction

標準概述:	圖款前肩帶需出紙樣的要求
STANDARD BRIEF:	Rqst Of Paper Pattern Of Front Shoulder Strap
執行日期:	2011年8月16日
EXCUTION DATE:	16-Aug-11
跟進人員:	紙樣組長/辦房車間
FOLLOW-UP STAFFS:	Pattern Team Leader / Sample Workshop

標準說明STANDARD EXPLANATION:

前肩帶需出紙樣的圖款,如果前后位寬度相差在0.5CM以內的,現統一紙樣不分前后; 如客人有特別要求按肩帶兩頭實際寬度出紙樣的,則需在前肩帶加厄位, 便於大貨生產.

For bras need paper pattern of shoulder strap,if with a difference below 0.5cm,presently,there's no need to distinguish F/B plm;But if with special rqts of making paper pattern as its atucal width,pls add notch to tell F/B.

1. 前肩帶需出紙樣的款式圖(肩帶前后區相差2mm)

.The following is a style which needs paper pattern for its shoulder strap.(F/B of strap has a difference of 2mm.)

舊做法: 按肩帶兩頭實際寬度出紙樣,即前后位相差2mm.

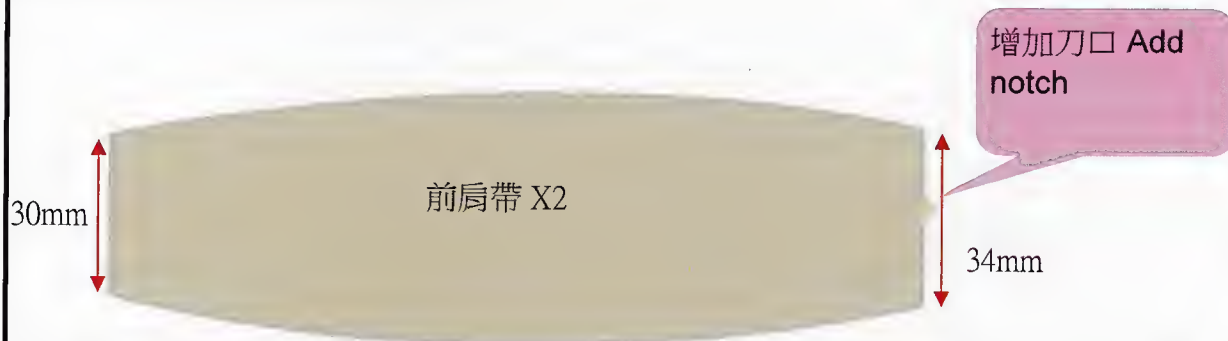
old method: make paper pattern as its atucal



新做法: 按肩帶兩頭較窄的寬度做紙樣,即前后位寬度相同.
newmethod:make paper pattern as shorter width,keep F/B accordant.

2. 如果客人特別要求按肩帶兩頭實際寬度出紙樣的,需在前耳仔位加刀口,以便區分前后位.

.If customers specially require to make paper pattern as atucal width,notch will be added on front loop-ear to distinguish F/B plm.



備注說明Remarks:

此法從即日新單開始.

The method will be adopted from now on.

標準概述:	T字棉圍款面布紙樣做法
STANDARD BRIEF:	Paper Pattern For Shell Fabric Of T Cut Padded Bra
執行日期:	2011年11月3日
EXCUTION DATE:	3-Nov-11
跟進人員:	紙樣組長/辦房車間
FOLLOW-UP STAFFS:	Pattern Team Leader / Sample Workshop

標準說明STANDARD EXPLANATION:

T字棉圍款棉上杯骨位加凸刀口對下杯棉骨,無需分大小碼.

For "T" cup of any size ,add salient on the paper pattern to show the seam of top cup should follow that of bottom cup.

款式圖示 style picture:

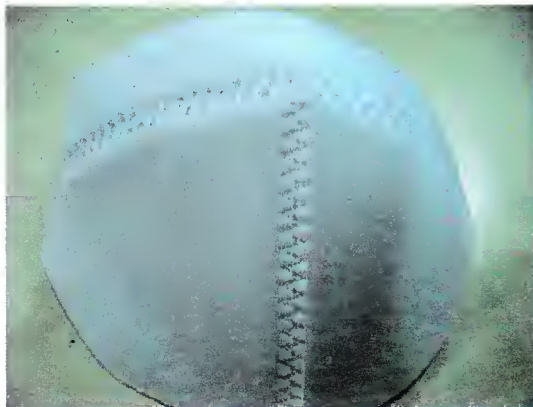


圖1. Picture 1.

1.圖1為T字棉圍款.

1.Pict.1 is a "T" cut padded bra.

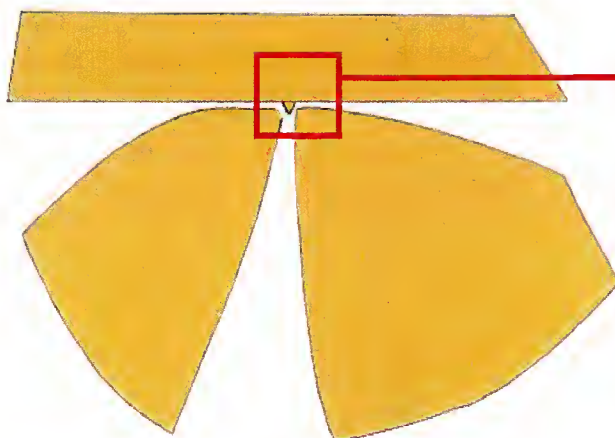


圖2. Picture 2.

2. 增加一凸刀口便於對齊下杯骨.

Add a bulge notch on pattern of top c to follow bottom cup seam .

備注說明Remarks:

標準概述:	手工打褶的款,做紙樣的要求
STANDARD BRIEF:	Rqts of paper pattern when need pleating manually
執行日期:	2011年11月3日
EXCUTION DATE:	3-Nov-11
跟進人員:	紙樣組長/辦房車間
FOLLOW-UP STAFFS:	pattern team leader / Sample workshop

標準說明STANDARD EXPLANATION:

手工打褶的款,大小碼打褶的個數不一樣的,紙樣員需在尺寸表上注明什麼碼打多少個褶。
 For bras pleating manually,if different sizes,different darts,paper patterners need to state it on size chart.

圖1. 手工打褶款:

picture1.

For bras pleating manually:

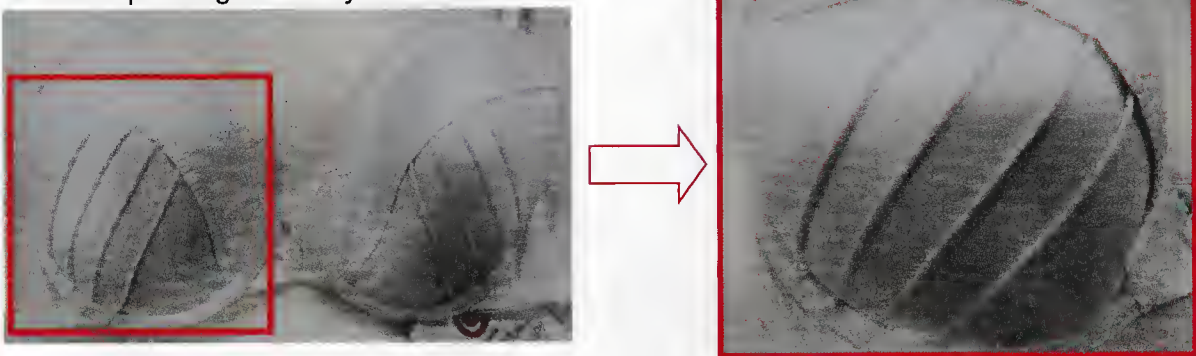


圖2. 尺寸表需注明的信息:

picture 2. fill information in size chart:

合隆技術標準中心(C&A)尺寸表

日期: 2011.11.03

製圖: 2011.11.03

審核: 2011.11.03

批准: 2011.11.03

部位	單位	尺寸
M1 下胸圍(最底)	cm	75
M2 上胸圍(最頂)	cm	85
M3 上胸圍(最頂)	cm	85
M4 上胸圍	cm	85
M5 上胸圍(最頂)	cm	85
M6 上胸圍(最頂)	cm	85
M7 上胸圍(最頂)	cm	85
M8 上胸圍(最頂)	cm	85
M9 上胸圍(最頂)	cm	85
M10 上胸圍(最頂)	cm	85
M11 上胸圍(最頂)	cm	85
M12 上胸圍(最頂)	cm	85
M13 上胸圍(最頂)	cm	85
M14 上胸圍(最頂)	cm	85
M15 上胸圍(最頂)	cm	85
M16 上胸圍(最頂)	cm	85
M17 上胸圍(最頂)	cm	85
M18 上胸圍(最頂)	cm	85
M19 上胸圍(最頂)	cm	85
M20 上胸圍(最頂)	cm	85
M21 上胸圍(最頂)	cm	85
M22 上胸圍(最頂)	cm	85
M23 上胸圍(最頂)	cm	85
M24 上胸圍(最頂)	cm	85
M25 上胸圍(最頂)	cm	85
M26 上胸圍(最頂)	cm	85
M27 上胸圍(最頂)	cm	85
M28 上胸圍(最頂)	cm	85
M29 上胸圍(最頂)	cm	85
M30 上胸圍(最頂)	cm	85
M31 上胸圍(最頂)	cm	85
M32 上胸圍(最頂)	cm	85
M33 上胸圍(最頂)	cm	85
M34 上胸圍(最頂)	cm	85
M35 上胸圍(最頂)	cm	85
M36 上胸圍(最頂)	cm	85
M37 上胸圍(最頂)	cm	85
M38 上胸圍(最頂)	cm	85
M39 上胸圍(最頂)	cm	85
M40 上胸圍(最頂)	cm	85
M41 上胸圍(最頂)	cm	85
M42 上胸圍(最頂)	cm	85
M43 上胸圍(最頂)	cm	85
M44 上胸圍(最頂)	cm	85
M45 上胸圍(最頂)	cm	85
M46 上胸圍(最頂)	cm	85
M47 上胸圍(最頂)	cm	85
M48 上胸圍(最頂)	cm	85
M49 上胸圍(最頂)	cm	85
M50 上胸圍(最頂)	cm	85
M51 上胸圍(最頂)	cm	85
M52 上胸圍(最頂)	cm	85
M53 上胸圍(最頂)	cm	85
M54 上胸圍(最頂)	cm	85
M55 上胸圍(最頂)	cm	85
M56 上胸圍(最頂)	cm	85
M57 上胸圍(最頂)	cm	85
M58 上胸圍(最頂)	cm	85
M59 上胸圍(最頂)	cm	85
M60 上胸圍(最頂)	cm	85
M61 上胸圍(最頂)	cm	85
M62 上胸圍(最頂)	cm	85
M63 上胸圍(最頂)	cm	85
M64 上胸圍(最頂)	cm	85
M65 上胸圍(最頂)	cm	85
M66 上胸圍(最頂)	cm	85
M67 上胸圍(最頂)	cm	85
M68 上胸圍(最頂)	cm	85
M69 上胸圍(最頂)	cm	85
M70 上胸圍(最頂)	cm	85
M71 上胸圍(最頂)	cm	85
M72 上胸圍(最頂)	cm	85
M73 上胸圍(最頂)	cm	85
M74 上胸圍(最頂)	cm	85
M75 上胸圍(最頂)	cm	85
M76 上胸圍(最頂)	cm	85
M77 上胸圍(最頂)	cm	85
M78 上胸圍(最頂)	cm	85
M79 上胸圍(最頂)	cm	85
M80 上胸圍(最頂)	cm	85
M81 上胸圍(最頂)	cm	85
M82 上胸圍(最頂)	cm	85
M83 上胸圍(最頂)	cm	85
M84 上胸圍(最頂)	cm	85
M85 上胸圍(最頂)	cm	85
M86 上胸圍(最頂)	cm	85
M87 上胸圍(最頂)	cm	85
M88 上胸圍(最頂)	cm	85
M89 上胸圍(最頂)	cm	85
M90 上胸圍(最頂)	cm	85
M91 上胸圍(最頂)	cm	85
M92 上胸圍(最頂)	cm	85
M93 上胸圍(最頂)	cm	85
M94 上胸圍(最頂)	cm	85
M95 上胸圍(最頂)	cm	85
M96 上胸圍(最頂)	cm	85
M97 上胸圍(最頂)	cm	85
M98 上胸圍(最頂)	cm	85
M99 上胸圍(最頂)	cm	85
M100 上胸圍(最頂)	cm	85

備註: 36C~38C打3個褶;
34D~38D打4個褶;
32DD~38DD打5個褶;
30E~38E打6個褶;

備註:	36C~38C打3個褶; 34D~38D打4個褶; 32DD~38DD打5個褶; 30E~38E打6個褶;
樣師傳: 2011.11.03	日期: 2011.11.03

備注說明Remarks:

標準概述:	有杯骨和下扒骨的款做紙樣時的要求
Standard summarise :	Rqts of paper pattern when having seam at top cup and cradle
執行日期:	2011年11月3日
Term of expiration date:	3-Nov-11
跟進人員:	紙樣組長/車間總指
Follow-up staffs:	Pattern team leader / Sewing team leader
標準說明:	有杯骨和下扒骨的款式,紙樣需在尺寸表上注明是還是無需對骨.
Standard explanation :	For bras having seam at cup and cradle,paper patterners need to state if they need to be aligned on size chart.

合隆技術發展中心(C&A圖)尺寸表 日期: _____

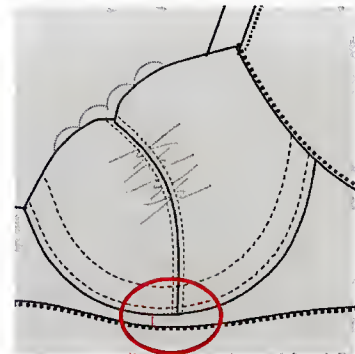
款號: 184-T-00410 姓名: 打 孔 編 紙樣號: _____

部位	說明	尺寸
M0	下胸平度第一勾圍	85.0
M10	上杆連包圍圍	68.0
M13	下杯高(下包圍圍)	20.8
M13B	上杯高	
M11	全杯高(包圍圍)	17.4
M11A	杯骨(下包圍圍)	
M11B	杯骨(包圍圍)	2.9
M20	上胸心圍 (4.8)	8.6
M9	下胸心圍 (4.8)	8.6
M14	網底長(沿邊度)	27.6
M21	肩帶長(從肩距5cm)	27.6
M20	上底寬(從肩距)	22.8
	腋底長	6.5
1	領心寬	5
2	比底(總度)	2
3	上比(從肩距)	14.8
4	下比(從肩距)	7.5
5	下比長(不計勾圍)	2.1
6	網底長	11.4
7	網底長	23.7
8	網底長(連勾圍)	25.8
9	網底長(連勾圍)	0.9
	網底長(連勾圍)	13.4
1	下胸大連圍(mm)	
2	肩帶長(mm)	
3	勾圍長(mm)	

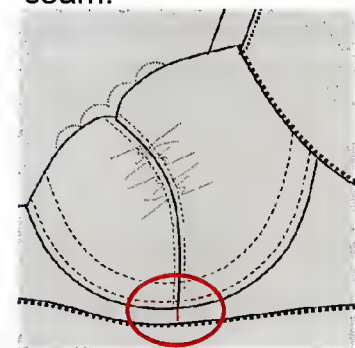
網底長: 0.44 * 1000 / 100 = 4.4 網底長: 0.44 * 1000 / 100 = 4.4

備註: 2.9 7.6 11.4 13.4

網底長: 0.44 * 1000 / 100 = 4.4



不需要對杯骨款式圖
Don't need to follow cup seam.



需對杯骨款式圖
need to follow cup seam

備註欄: 在此注明: "杯骨需對下扒骨" 或 "杯骨不需對下扒骨"
need to remark: "Don't need to follow cup seam" or " need to follow cup seam"

有杯骨與下扒骨的款,紙樣需在尺寸表上注明是否對骨.(對與不對骨否都須表明清楚)
For bras having seam at cup and cradle,paper patterners need to state on size chart whether they need to be aligned.

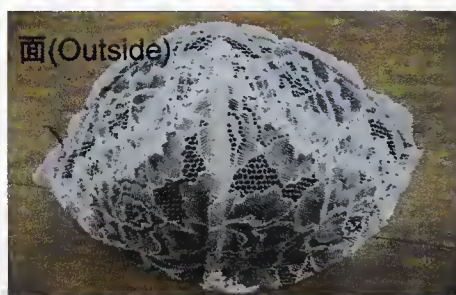
備註說明Remarks:

標準概述:	拼棉圖的杯骨紙樣做法
STANDARD BRIEF:	How To Make Paper Pattern Of Cup Seam For Join-pad Bras
執行日期:	2011年4月6日
EXCUTION DATE:	6-Apr-11
跟進人員:	紙樣組長/車間總指
FOLLOW-UP STAFFS:	Paper Pattern Team Leader/Sewing Team Leader

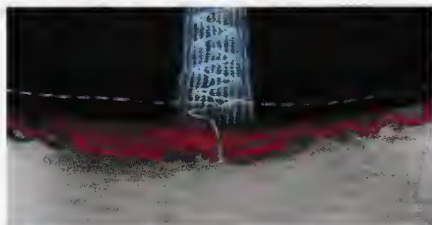
標準說明STANDARD EXPLANATION:

拼棉圖, 面杯是花邊的, 且面杯與棉杯之間沒有加多一層布的款式, 面布杯骨需与棉杯骨對齊(即蓋骨).
If shell of join-pad bra is lace and there have no more fabric between shell & pad, seam on top cup should be aligned with foam seam.

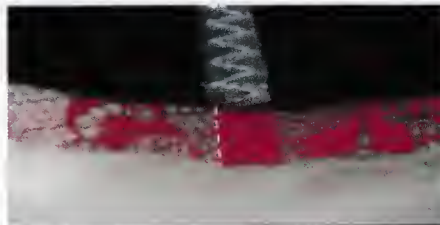
1. 款式圖(Picture of style)



2. 車縫骨位對照圖(Contrast pictures of cup seam sewing)

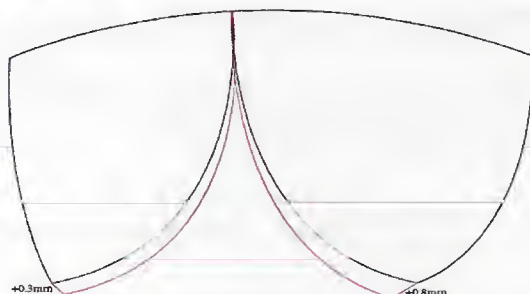


舊做法: 面杯車縫接駁位与拼棉骨位中間對齊.
(Old method: sewing joint of top cup is aligned in the middle of



新做法: 面杯車縫止口位需蓋住拼棉骨位.
(New method: sewing allowance of top cup has to cover foam

3. 紙樣制作圖(Picture of paper pattern making)



克色線: 棉紙樣
紅色線: 面布紙樣
Black line represents padding pattern

備注說明Remarks:

合隆技術標準指引

HopLun Technical standard direction

標準概述:	雪紡面料出紙樣時的要求
STANDARD BRIEF:	Rqst Of Paper Pattern Of Chiffon Fabric
執行日期:	2011年4月6日
EXCUTION DATE:	6-Apr-11
跟進人員:	紙樣組長
FOLLOW-UP STAFFS:	Paper Pattern Leader

標準說明STANDARD EXPLANATION:

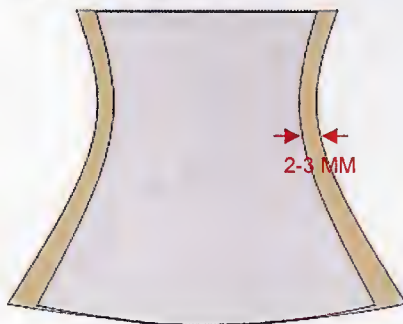
雪紡布面料易散絲,出紙格時圍款每邊各加大2MM,褲款前後浪骨位左右各加大2-3MM.

For chiffon fabric is easy to come loose,we need to add 2MM more at edges of bra and 2 to 3 MM more at F/B crotch wing when making the paper pattern.

1.雪紡布料款式圖(Picture of chiffon fabric style)



2.以褲款紙樣圖為例(Picture of paper pattern of gusset for example)

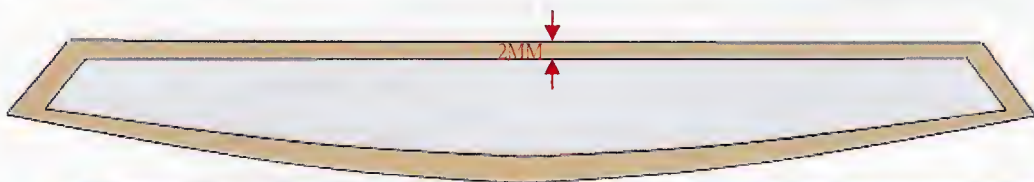


該顏色代表紙格
the color represents the size of paper pattern



該顏色代表雪紡布料
the color represents the size of chiffon fabric

3.圍款以下扒荷葉邊紙樣為例:(Picture of paper pattern of cradle for example)



該顏色代表紙格
the color represents the size of paper pattern



該顏色代表雪紡布料
the color represents the size of chiffon

備注說明Remarks:

實際加大的止口需根據雪紡布的散絲而定

How much the allowance we actually need to add depends on the allowance of the chiffon fabric.

標準概述:	雞心破骨的款式
Standard summarise :	The Style Of Cutting Seam At Gore
執行日期:	2011年11月3日
Term of expiration date:	3-Nov-11
跟進人員:	紙樣組長/辦房車間
Follow-up staffs:	Pattern Team Leader / Sample Workshop

標準說明STANDARD EXPLANATION:

當圍款雞心/下巴/比位的面料是花邊喱士時, 紙樣統一做法為: 面料---雞心中間破骨, 下扒位不破骨(如圖2); 定型紗---雞心/下扒/比位需破骨(如圖3).

When C.F & cradle & wing of bra use lace ,pls adopt the following method: Shell---cut seam at C.F, while the cradle not(as pict.2); lining---cut seam @ gore and cradle and wing.(as pict.3)

圖1 . 款式圖 Picture 1. style picture.

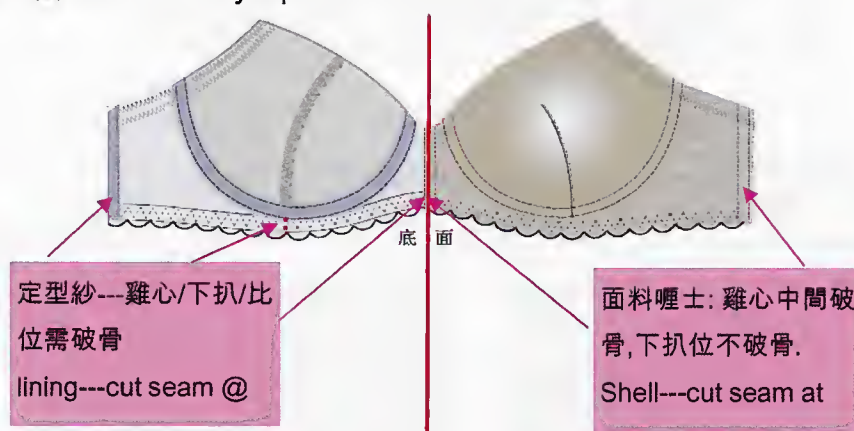


圖2. 面布紙樣: 下巴不破骨

Picture: Pattern of shell fabric: cradle needn't to be cut.

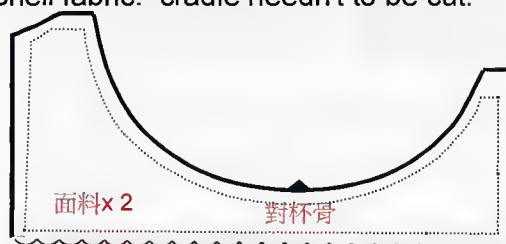


圖3. 里布(定型紗) 紙格, 雞心/側骨/下扒需破骨

Picture 3. Pattern of stiff lining: gore and side wing and cradle need to be cut.

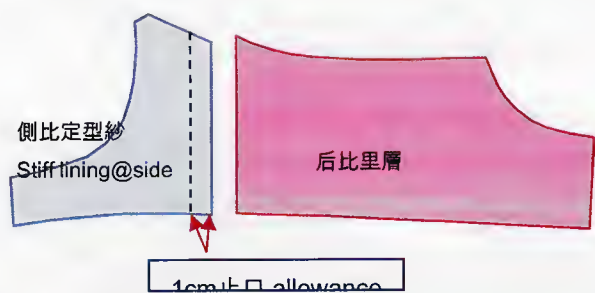


備注說明Remarks:

標準概述:	圖款雙層比裡層破骨做法
STANDARD BRIEF:	How to Break Seam For Two Layers At Side Seam Of Bra
執行日期:	2011年6月20日
EXCUTION DATE:	20-Jun-11
跟進人員:	紙樣組長/車間總指導
FOLLOW-UP STAFFS:	Pattern team leader / Sewing team leader

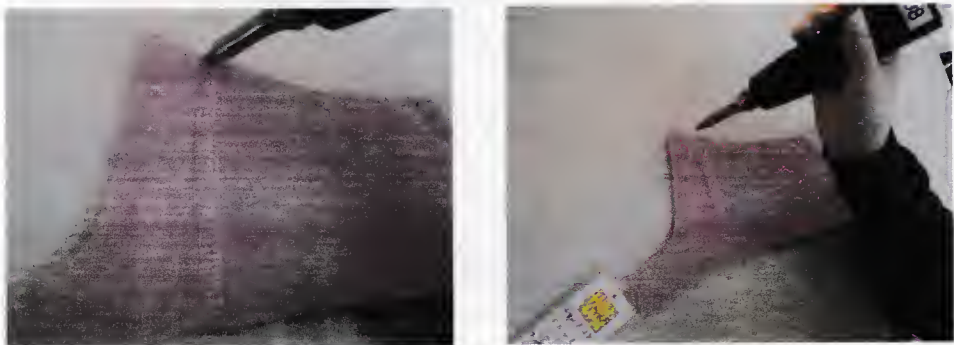
標準說明STANDARD EXPLANATION:

1. 紙樣制作 Patterning making :



2. 車縫制作 Sewing Making :

- 1) 使用手提式超聲波機定點位。
.To use the portable ultrasound machine fixup the point .



2) 用雙針5/16針位棟比, 綑條由上吊落, 在車縫時便於看到布料的止口。

.Use 5/16" t/n sewing side seam, and hang binding from high. so it is easy to see the fabric seam allowance when hanging .


底面朝上 Bottom is upwards.



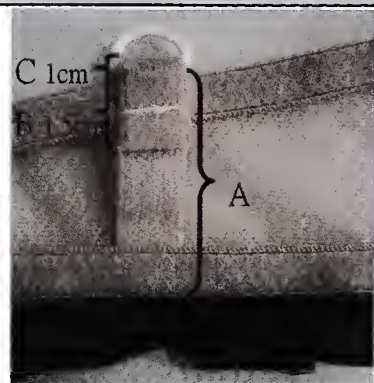
備注說明Remarks:

標準概述:	如何計算后耳仔剪長
STANDARD BRIEF:	How to count back loop-ear cutting length
執行日期:	2011年8月16日
EXCUTION DATE:	16-Aug-11
跟進人員:	紙樣組長/辦房車間
FOLLOW-UP STAFFS:	pattern team leader / Sample workshop
標準說明STANDARD EXPLANATION:	

1. 耳仔与上比橡根平齊的款式 Back loop-ear is aligned with elastic @top wing

圖示Illustration	耳仔封度 width of back-loop	耳仔剪長尺寸公式 Measure formula of back-loop cutting length
	$\leq 1.2\text{cm}$	$A+B$
	1.3cm~1.6cm	$A+B+0.2\text{CM}$
	1.7~2cm	$A+B+0.4\text{CM}$

2. 耳仔外露出 0.5CM的款式 Back loop-ear is 0.5 higher than elastic @top wing

圖示Illustration	耳仔封度 width of back-loop	耳仔剪長尺寸公式 Measure formula of back-loop cutting length
	$\leq 1.2\text{cm}$	$A+B+C$
	1.3~1.6cm	$A+B+C+0.2\text{CM}$
	1.7~2cm	$A+B+C+0.4\text{CM}$

A: 比高度 Wing height

B: 預留打褸時折止口長度 Seam allowance perpared for bartack

C: 外露出上比(0.5CM*2倍等於1CM) Protruding part length(0.5CM x 2=1CM)

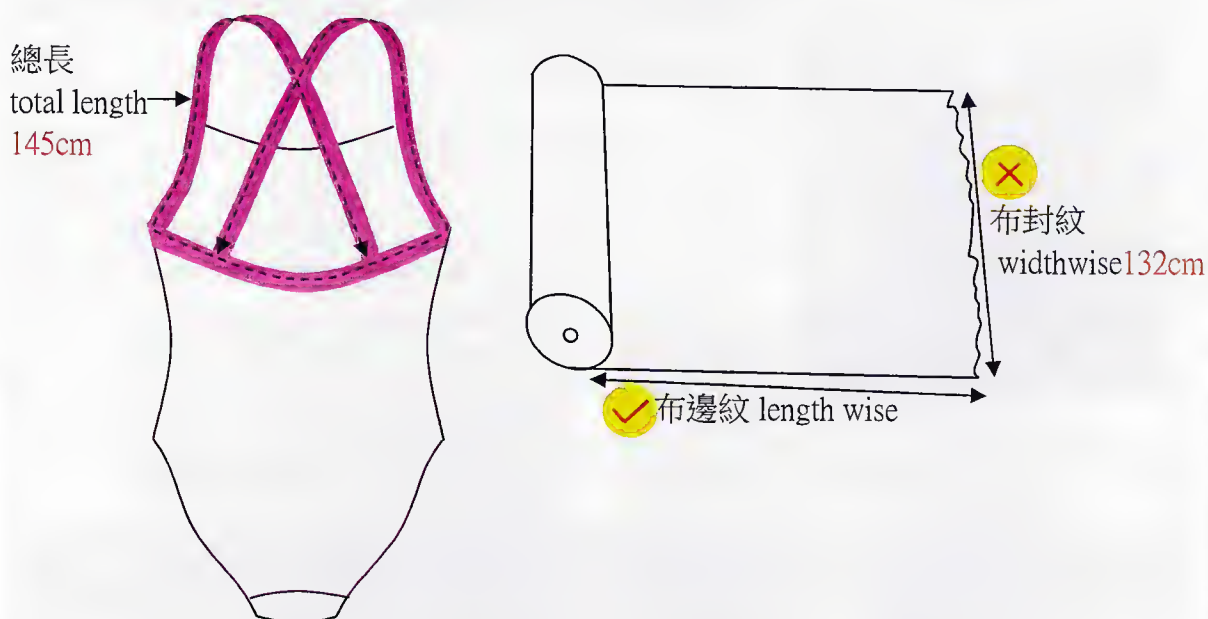
備注說明Remarks:

標準概述:	紙樣員需考慮節省成本的問題
STANDARD BRIEF:	The Paper Patterner's Consideration Of Cost Saving .
執行日期:	2011年11月28日
EXCUTION DATE:	28-Nov-11
跟進人員:	紙樣組長/紙樣員
FOLLOW-UP STAFFS:	Pattern Team leader / Paper patternner

標準說明STANDARD EXPLANATION:

1. 採用封度紋捆條時需考慮封度是否夠長.

.You need to consider the adequacy length of width when using it to binding .



上圖的連身衣款粉紅色部份是用企車包細條, 總長為145CM, 而布料的封度只有 132cm, 所以此款不能使用布封紋. 應使用布邊紋.

.Prink fill part of upper picture is being used to binding by coverstitch, the total length is 145cm, but the fabric width is only 132cm, so the width grain can't be used on this style . but to use length grain .

備注說明Remarks:

標準概述:	如果紙樣上有特別備注的需在工藝書上注明清楚.
STANDARD BRIEF:	Make It Clear In Operation Chart If Pattern Have Special Remarks
執行日期:	2011年1月21日
EXCUTION DATE:	21-Jan-11
跟進人員:	紙樣組長/工藝員
FOLLOW-UP STAFFS:	Pattern Team Learder / Craft

標準說明STANDARD EXPLANATION:

- 1.舉例款圖,在工藝書的款式大圖上注明特別留意的信息.
Example of style: Marking information need to be paid more attention on pictures of craft book.

He Xun(DG) Technical Development Centre Bra Measurement Table(339)			
合迅(東莞)技術部圍尺寸表(339)			
Style No款號:339-I-00100墊MP	Program組名:雙層組	Factory工廠:A	Unit单位: INCH
<div> <div>注:難易級別:C</div> <div>注:左右杯條子對稱.</div> </div>			



杯位左右花需對稱的註明

Symmetrical flowers on both L&R cups

備注說明Remarks:



合隆技術標準指引

HopLun Technical standard direction

標準概述:	下扒位面布是花邊內加定型紗款式的紙樣做法
STANDARD BRIEF:	Paper pattern of lace within fixed net at cradle fabric
執行日期:	2015年3月26日
EXCUTION DATE:	26-Mar-15
跟進人員:	紙樣組長/車間
FOLLOW-UP STAFFS:	Paper pattern/ Sewing room
標準說明STANDARD EXPLANATION:	
<p>下扒位面布是花邊內加定型紗款式。建議下扒位將里層定型紗比面層花邊紙格出小2MM(參考398-L-00019款光杯花邊組)</p> <p>The style of lace with stibilizer at cradle, suggesting that inner stabilizer is 2MM smaller than shell lace pattern. (example:398-L-00019)</p> <div></div>	
備注說明Remarks:	
<p>下扒位面布是花邊內加定型紗款式。統一下扒位將里層定型紗比面層花邊紙格出小2MM.(註:包括下扒位倒網/順網款式)</p> <p>Unify that inner stabilizer pattern is 2MM smaller than shell lace pattern for the style of lace with stabileze at cradle.(Notice: Including the styel of seam allowance of upper cup towards cup & seam allowance of upper cup towards front underbust)</p>	

標準概述:	大小碼針位
STANDARD BRIEF:	Stitch for small & large size
執行日期:	2015年4月28日
EXCUTION DATE:	28-Apr-15
跟進人員:	紙樣組長/車間
FOLLOW-UP STAFFS:	Paper pattern/ Sewing room
<p>標準說明STANDARD EXPLANATION:</p> <p>關於前肩帶底托丈根或細條的.大小碼需要用不同的針位.討論在那個環節提供針位.(參考 168-P-00099款)</p> <div data-bbox="448 982 856 1413" data-label="Image">  </div> <div data-bbox="155 1415 705 1849" data-label="Image">  </div> <div data-bbox="723 1415 1280 1849" data-label="Image">  </div>	
<p>備注說明Remarks:</p> <p>統一由紙樣在物料卡上備註清楚大小碼針位.</p> <p>Patterns on material card uniformly and clearly remark the needle of S and L size.</p>	



合隆技術標準指引

HopLun Technical standard direction

標準概述:	大碼杯的做紙樣做法
STANDARD BRIEF:	Paper pattern of large size
執行日期:	2015年4月28日
EXCUTION DATE:	28-Apr-15
跟進人員:	紙樣組長/車間
FOLLOW-UP STAFFS:	Paper pattern/ Sewing room

標準說明STANDARD EXPLANATION:

下杯大碼是立體,面布要沿升到頂點上的(參考445-L-00220C款如附件圖片此款是出紙格的,杯骨中間剪口至剪口位要先單針縮折後夾碗,大貨很難做,完成不靚)討論類似款式下杯位是否做模杯.

The large size of lower cup is solid, and shell fabric is to the peak. (Take 445-L-00220C for example. As the attached picture, this one is for paper pattern. The notch in the middle of cup seam to notch should firstly use s/n 1/s to fold and then join cup. It is difficult to make stock production, and they are not nice-looking.) Discussing whether the lower cup of similar style should make mould cup.



備注說明Remarks:

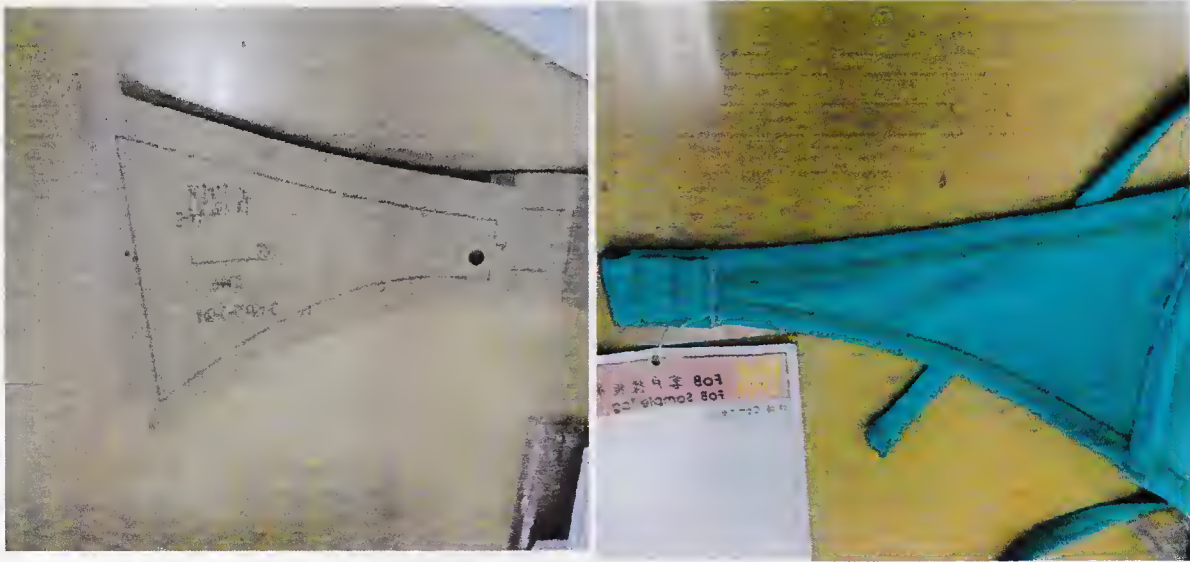
以後如遇到此類情況,如遇到問題改善不了的時候要及時反饋給客人.讓客人批標準
If we meet the similar situation in the future and we can not solve them, we should give feedback to customer and let them give standards.



合隆技術標準指引

HopLun Technical standard direction

標準概述:	公差问题
STANDARD BRIEF:	Tolerance
執行日期:	2014年11月25日
EXCUTION DATE:	25-Nov-14
跟進人員:	紙樣組長/紙樣技術員
FOLLOW-UP STAFFS:	Paper pattern/Technician
標準說明STANDARD EXPLANATION:	
<p>1)除了008鷄心尺寸和038童裝尺寸有0公差,圍及褲款拉度尺寸,建議客人有公差的,全部按客人的公差執行,(其中包括客人用儀器來度拉度的)客人公差是0的需与客人提出. 2)客人圍和褲沒有公差尺寸的,則按褲頭,褲腳,下腳的公差+為標準,-則為0.</p> <p>Except that 008 gore measurement and 038 children's garments measurement have 0 public errand, suggests that all of them should be made according to customer's public errand if customer has public errand. (Including that they use instrument to measure 拉度。)If the public errand of customer is 0, it is necessary to put forward with customer.2) If there is no public errand about 客人围 and shorts, according to public errand+ of waistband, leg opening and bottom hem as standard, and - as 0.</p>	
備注說明Remarks:	

標準概述:	比位里布比面布短的紙樣做法
STANDARD BRIEF:	Paper pattern of lining shorter than fabric at wing
執行日期:	2014年3月20日
EXCUTION DATE:	20-Mar-14
跟進人員:	紙樣
FOLLOW-UP STAFFS:	Paper pattern
<p>標準說明STANDARD EXPLANATION:</p> <p>1:針對比位裡布比面布短,需反折比尾打三個棗款式,因里布回縮較大車間打棗后易爆口。統一左比里布紙格在加長0.5CM Aim at lining is shorter than shell fabric at wing, and fold wing tail to bartack*3, and broken easily after bartack for big shrinkage, so lengthen lining paper pattern 0.5CM</p> <p>2:針對所有三線級骨拉膠片,防止膠片露白,建議加大1MM布邊止口 All 3th o/l attach rubber band, avoid rubber band visible outside, so increase 1MM edge seam allowance</p> <div data-bbox="87 1037 1266 1599" data-label="Image">  </div>	
<p>備注說明Remarks:</p> <p>第1點已與紙樣統一,第2點待板車間各總指與工藝組共同測試後下個月會時再討論 Point 1 has already been consistent with paper patterns. Point 2,after common test between plate workshop and technology group, it will be discussed again in next monthly meeting.</p>	



合隆技術標準指引

HopLun Technical standard direction

標準概述:	左右杯需對條對色款的紙樣做法
STANDARD BRIEF:	Paper pattern of matching coulor and strips at R/L cup
執行日期:	2014年3月20日
EXCUTION DATE:	20-Mar-14
跟進人員:	紙樣
FOLLOW-UP STAFFS:	Paper pattern
標準說明STANDARD EXPLANATION:	
<p>左右杯需對條,對色的款,杯紙格連體位需統一連雞心位.不可以在夾彎位</p> <p>Left and right cup need to match strip and match color, mould cup pattern need to link center front rather than underarm.</p> 	
備注說明Remarks:	



合隆技術標準指引

HopLun Technical standard direction

標準概述:	有飾物的齊碼杯做法
STANDARD BRIEF:	Size set sample cup with decoration
執行日期:	2014年3月20日
EXCUTION DATE:	20-Mar-14
跟進人員:	紙樣
FOLLOW-UP STAFFS:	Paper pattern

標準說明STANDARD EXPLANATION:

樣板吊落花邊及穿絲帶,丈巾的,齊碼杯也需要吊落花邊及穿絲帶.丈巾,以便給大貨工廠准確的參考

Sample with hang&attach lace, silk ribbon and elastic, size set sample cup also need hang&attach lace, silk ribbon and elastic, which is convenient for factory to make a accurate reference.



備注說明Remarks:



合隆技術標準指引

HopLun Technical standard direction

標準概述:	所有拉度尺寸給正公差
STANDARD BRIEF:	Positive tolerance for all extension measurement
執行日期:	2014年3月20日
EXCUTION DATE:	20-Mar-14
跟進人員:	紙樣
FOLLOW-UP STAFFS:	Paper pattern
標準說明STANDARD EXPLANATION:	
<div>尺寸表上所有拉度尺寸只能給正公差，不能給負公差</div> <div>There is only positive tolerance for all extension measurement on size chart.</div>	
備注說明Remarks:	



合隆技術標準指引

HopLun Technical standard direction

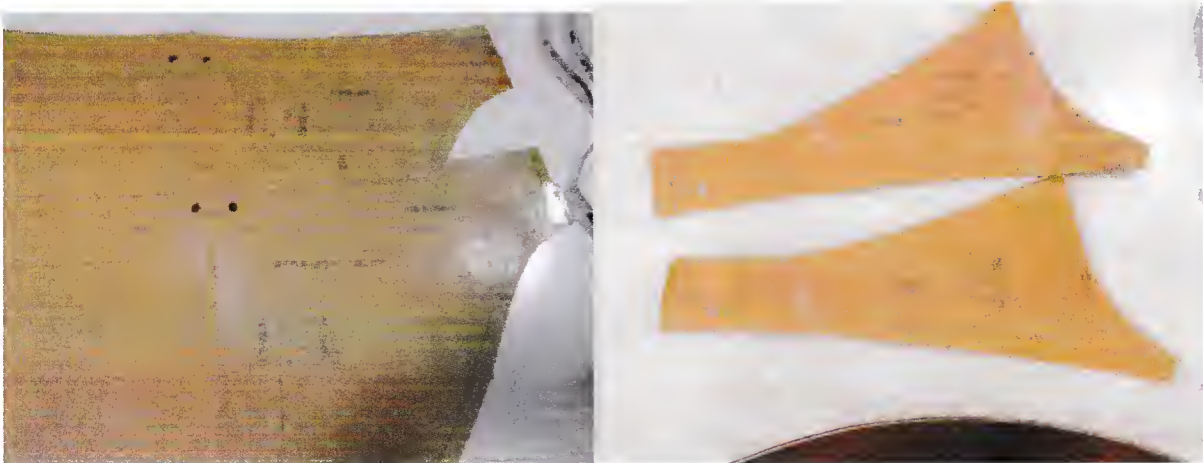
標準概述:	放碼OK尺寸表蓋章
STANDARD BRIEF:	Put seal on grading size chart
執行日期:	2014年3月20日
EXCUTION DATE:	20-Mar-14
跟進人員:	紙樣
FOLLOW-UP STAFFS:	Paper pattern


標準說明STANDARD EXPLANATION:

放碼OK的尺寸表上現都需蓋《大貨放碼OK》章,從2014-3-24紙樣手上的新單開始實行
Put seal on size chart if graded OK with 《Bulk grading OK》.Take action from 2014-03-24.



備注說明Remarks:

標準概述: STANDARD BRIEF:	泳衣里布拉單張的紙樣做法
執行日期: EXCUTION DATE:	2014年3月20日 20-Mar-14
跟進人員: FOLLOW-UP STAFFS:	紙樣 Paper pattern
標準說明STANDARD EXPLANATION:	
<p>針對泳衣裡布拉單張裁的款式,紙樣上統一的寫法為拉單張,面朝上或者裡朝上.紙樣上字體的寫法需與面層同方向,不要以合掌的形式寫,按附圖示標準</p> <p>Aim at swimwear 裡布拉單張裁的款式, the style of writing of paper patterns should be written into 拉單張, the surface is up or lining is up.The writing style of written characters on paper patterns should be in the same direction as surface course. To write according to the standards of attached pictures rather than face to face.</p>	
	
備注說明Remarks:	


標準概述:	前幅有八字形花邊款式的紙樣做法
STANDARD BRIEF:	The paper pattern of eight shaped lace at front panel
執行日期:	2014年3月20日
EXCUTION DATE:	20-Mar-14
跟進人員:	紙樣
FOLLOW-UP STAFFS:	Paper pattern
標準說明STANDARD EXPLANATION:	
<p>只針對前幅有八字形花邊的款式,以高波計低於(包括)2.5CM的統一吊落,如客有特別要求花波需對稱及高波計2.5CM以上的統一出紙樣,</p> <p>Only for front panel with "八" lace. High scallop less than 2.5CM is uniformly required to hang and attach. If customer has special requests that scallop should be symmetrical, and high scallop is more than 2.5 CM, paper patterns can be made.</p>	
	
備注說明Remarks:	



合隆技術標準指引

HopLun Technical standard direction

標準概述:	倒摺碗與順摺碗的下扒骨位
STANDARD BRIEF:	cradle
執行日期:	2014年3月20日
EXCUTION DATE:	20-Mar-14
跟進人員:	紙樣
FOLLOW-UP STAFFS:	Paper pattern
標準說明STANDARD EXPLANATION:	
<div>1：倒摺碗款式10MM（不包括10MM）以上的款下扒紙格骨位与丈极宽度一致（特别布料除外）；</div> <div>2：顺摺碗款式下扒紙格骨位都是：下比丈根宽度+2MM（特殊布料除外）</div>	
備注說明Remarks:	

標準概述:	破骨/T字骨的紙樣做法
STANDARD BRIEF:	Paper pattern of cut seam & T cut seam
執行日期:	2014年7月3日
EXCUTION DATE:	3-Jul-14
跟進人員:	紙樣組長/紙樣技術員
FOLLOW-UP STAFFS:	Paper pattern leader/Technician
<p>標準說明STANDARD EXPLANATION:</p> <p>1:下杯是破骨,只針對打凸刀口的布料,需將分辨杯骨的剪口移到近碗圈摺碗的位置,目的是使單針夾杯骨後外觀順直,例:(如圖1)</p> <p>2:T字杯的款式,下杯橫骨的位置紙樣止口位需出切角,不可出尖角,目的是使夾襟下杯骨後,沒有尖角露出(如圖2)</p> <div> <div> <p>圖1</p>  </div> <div> <p>圖2</p>  </div> </div>	
備注說明Remarks:	



合隆技術標準指引

HopLun Technical standard direction

標準概述:	側骨位紙樣
STANDARD BRIEF:	Paper pattern of side seam
執行日期:	2015年6月1日
EXCUTION DATE:	1-Jun-15
跟進人員:	車間
FOLLOW-UP STAFFS:	Production line in sample room
標準說明STANDARD EXPLANATION:	
<p>關於前/後幅兩種布料且彈性不一樣的款,紙樣側骨位出的是弧形,車間建議改出直的,因弧形紙樣影响车缝效率,如SCA15-2382款.</p> <p>About front / back panel whose fabric and elasticity are different, side seam on paper pattern is cambered. Workshop suggests that it should be straight because cambered paper patterns will influence sewing efficiency. For example, style SCA15-2382.</p>	
<div></div>	
備注說明Remarks:	

標準概述:	統一耳仔位出平角
STANDARD BRIEF:	Unify to the flat angle at loop
執行日期:	2015年4月28日
EXCUTION DATE:	28-Apr-15
跟進人員:	紙樣組長/車間
FOLLOW-UP STAFFS:	Paper pattern/ Sewing room

標準說明STANDARD EXPLANATION:

關於杯邊及夾彎運反款式,杯夾頂耳仔位有的款紙樣出的是V形(如445-N-00216A/B/C),有的出的是平角(445-K-00548),見附圖,因V形紙樣杯邊及夾彎鋁骨後易多布,工廠建議統一出平角跟附件內白色面布(445-K-00548款)

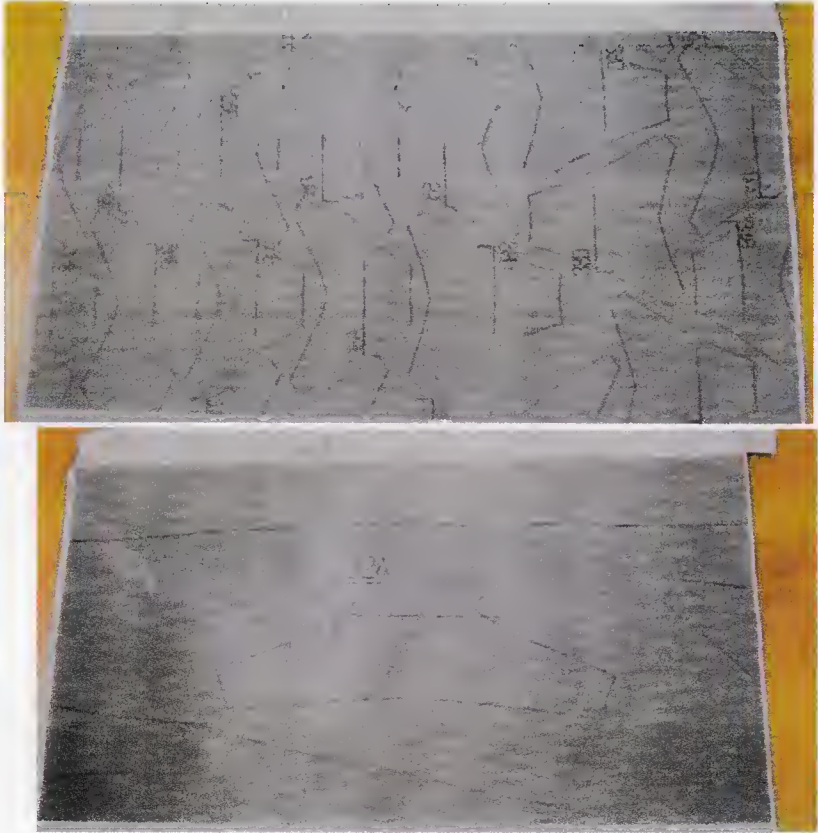
For front neckline and armhole are bagged out , some loop at apex pattern make V-shape,example as 445-N-00216A/B/C,some are flat angle, as sketch, caused excessive fabric after o/l for V-shape pattern. Suggest that make flat pattern, example as 445-K-00548.




備注說明Remarks:

統一耳仔位出平角.(如做板時發現還有出V型,需向模杯房反映)

Uniformly, loop made into flat angle. (please reflect to mould cup room if they still make V-shape paper patterns.)

標準概述:	裁片較小部位的注意事項
STANDARD BRIEF:	Note of cut piece for small part
執行日期:	2014年7月3日
EXCUTION DATE:	3-Jul-14
跟進人員:	紙樣組長/紙樣技術員
FOLLOW-UP STAFFS:	Paper pattern leader/Technician
<p>標準說明STANDARD EXPLANATION:</p> <p>For example, the small part of all cutting piece in the right picture, when paper pattern technician insert note on the computer, note must be put in the middle of paper pattern and it can not be too long lest it is printed beyond the paper pattern.</p> <p>如右圖所有裁片較小的部位,紙樣師傅在電腦里插入注解線時,一定要放在紙格的中間位置且注解線不可太長,以避免打印出來時超出紙格。</p> <div data-bbox="172 1002 982 1835">  </div>	
備注說明Remarks:	

標準概述:	避免起眼袋的紙樣做法
STANDARD BRIEF:	Paper pattern of avoiding eyelet
執行日期:	2014年3月20日
EXCUTION DATE:	20-Mar-14
跟進人員:	紙樣
FOLLOW-UP STAFFS:	Paper pattern
標準說明STANDARD EXPLANATION: <p>单针上碗要求拉长比弯位1/8-3/8",完成后起眼袋或容皱不均,影响外观及员工车缝难度大。只限於拉大1/4"以下的可以在尺寸表上注明,1/4"以上的需修改紙樣弧度避免起眼袋嚴重</p> <p>s/n l/s front neckline requires to be stretched 1/8-3/8" wing curve, it will have eyelet or uneven wrinkle, which influences its appearance. Also, it will be more difficult for workers to sew. s/n l/s front neckline can be Indicated on size spec if it is stretched less than 1/4. Otherwise, s/n l/s front neckline more than 1/4 is required to modify camber of paper pattern</p> 	
備注說明Remarks:	

標準概述:	雙針縮皺且散絲的紙樣做法
STANDARD BRIEF:	Paper pattern of shrinkage with T/N and fraying
執行日期:	2014年3月20日
EXCUTION DATE:	20-Mar-14
跟進人員:	紙樣
FOLLOW-UP STAFFS:	Paper pattern

標準說明STANDARD EXPLANATION:

針對雙針一次性縮皺且散絲的布料,紙樣統一在色卡裡寫上捆條寬度,還需備注捆條成品寬度,以方便各工廠計算紙樣到底加大了多少散絲的損耗

For t/n l/s with one-off shirr and filoselle fabric, paper pattern uniformly is required to write the width of binding tape on colour atlas and remark the width of finished binding tape so as to be convenient for all factories to calculate how much wastage does paper pattern increase.



備注說明Remarks:



合隆技術標準指引

HopLun Technical standard direction

標準概述:	雞心里紗紙樣
STANDARD BRIEF:	Paper pattern of C/F lining soft mesh
執行日期:	2013年10月22日
EXCUTION DATE:	22-Oct-13
跟進人員:	紙樣組長/紙樣技術員
FOLLOW-UP STAFFS:	Paper pattern/Technician
標準說明STANDARD EXPLANATION:	
<p>有下扒的款式，雞心紗或側比紗的下扒位段里紗高度無需加大容量，里紗高度跟面紙格出一樣大。</p>	
	
備注說明Remarks:	



合隆技術標準指引

HopLun Technical standard direction

標準概述:	雞心捆紙樣
STANDARD BRIEF:	CF Binding pattern
執行日期:	2014年11月25日
EXCUTION DATE:	25-Nov-14
跟進人員:	紙樣組長/紙樣技術員
FOLLOW-UP STAFFS:	Paper pattern/Technician
標準說明STANDARD EXPLANATION:	
<p>雞心丈根為吊落用丈根寬的,工廠建議上雞 心面布出捆條,丈根與捆條一次性吊落後再交由裁床按實樣裁,因丈根寬,雞心布出紙樣,車間需按修實樣剪丈根角度非常慢.(168-N-00087), 新單如鷄心腳是平的,新單鷄心面出捆條,再吊丈巾,最後按實樣裁.</p> <p>Hang & attach wide elastic at gore, factory suggests that fabric of upper gore is made into binding tape. After one-off hang&attach, elastic and binding tape are delivered to cuting table to let them cut as actuality. Because elastic is wide and fabric of gore is made into paper pattern, it is too slow for workshop to cut elastic angle(168-N-00087).For flat gore bottom, fabric of gore should be made into binding tape from new SO,and then hang&attach elastic, finally, cut as actual paper patterns.</p> 	
備注說明Remarks:	

標準概述:

需要發二加工款的紙樣

STANDARD BRIEF:

Paper pattern need 2nd process

執行日期:

2013年10月22日

EXCUTION DATE:

22-Oct-13

跟進人員:

紙樣組長/紙樣技術員

FOLLOW-UP STAFFS:

Paper pattern/Technician

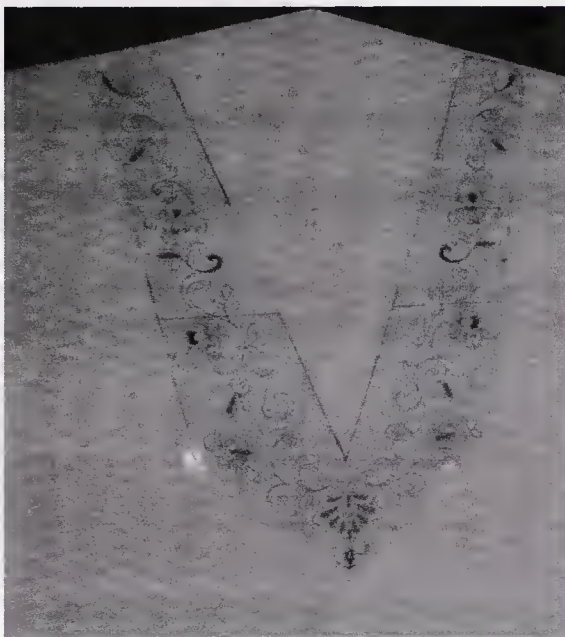
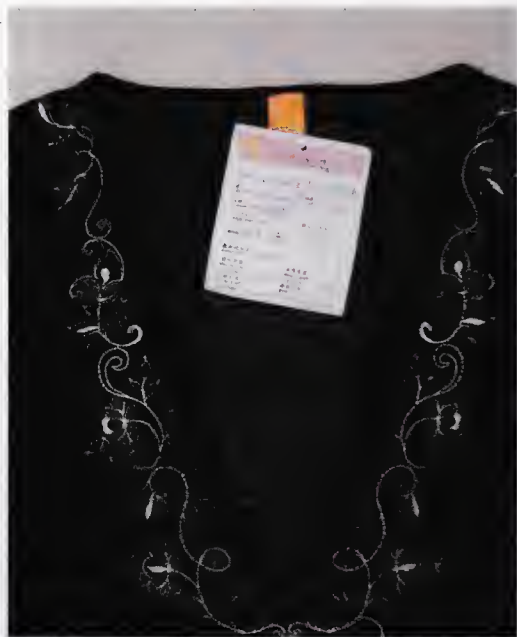
標準說明STANDARD EXPLANATION:

1. 需要發二加工款,布邊易散絲的款,統一紙樣要在板單上註明是否增加單針走線定位后,再外發二加工.

For the styles need to 2nd process and the selvage be filose easily, paper pattern need to mark whether add location s/n stitch at the record list

2. 需要二加工后修剪多餘子口款式,紙格只有裁樣,沒有實樣,紙樣師傅要在尺寸表上及紙格上註明二加工后需修掉某一部位多餘子口

If need to cut excess seam allowance after 2nd process,because there is only cut pattern without real pattern, paper pattern need to mark"cut some excess seam allowance after 2nd process" at size chart and pattern.



備注說明Remarks:



合隆技術標準指引

HopLun Technical standard direction

標準概述:	關於側杯斜度的紙樣
STANDARD BRIEF:	Paper pattern of side cup lean angle
執行日期:	2015年4月28日
EXCUTION DATE:	28-Apr-15
跟進人員:	紙樣組長/車間
FOLLOW-UP STAFFS:	Paper pattern/ Sewing room

標準說明STANDARD EXPLANATION:

445-N-00267A款紙樣下腳包1CM只口，兩側包綑條完成尺寸要保持一致,然而杯側邊由於碗底的弧度越小碼側斜度越大,包下腳捆工時很難控制杯側位斜角尺寸.建議紙樣改小杯側邊斜度.類似款式請紙樣都特別留意.

Sweep of style 445-N-00267A on paper pattern wraps 1cm seam allowance,the size of binding tape wrapping 2 sides must be consistent. However, the smaller camber of cup bottom is, the larger size slope is. So it is hard to control size of bevel of cup side while wrapping underbust. Suggests that make down bevel of cup side on paper pattern. Be careful for similar style.



備注說明Remarks:

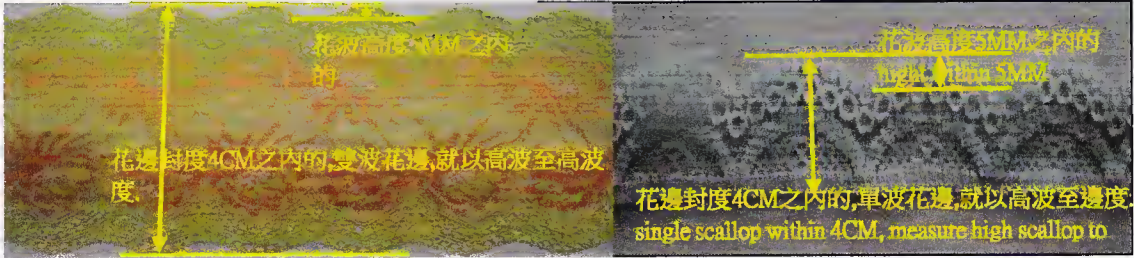
下水調整紙樣斜度

Adjust paper pattern's bevel while entering water.



合隆技術標準指引

HopLun Technical standard direction

標準概述:	4CM之內花邊吊落做法標準
Standard summarise :	Standard of hanging & attaching lace within 4CM width
執行日期:	2014年3月20日
Term of expiration date:	20-Mar-14
跟進人員:	紙樣組/辦房車間/工藝組
Follow-up staffs:	Pattern Team/Workshop/Technology team
標準說明:	
Standard explanation :	<p>單波或雙波花邊，高波度至高波是4CM之內，花邊波位高度是5MM之內的款(見圖1)，統一用人字車加用筒吊落平低波車.具體內容見下面3點:Single or double scallop, height between high scallop within 4CM, scallop height within 5MM, unify that alligns with valley to hang & attach to sew by ZZ with folder</p> <p>(1)單/雙波花邊封度高波至高波是4CM之內的款用筒吊落車.Hang & attach to sew by folder for single or double scallop, height between high scallop within 4CM</p> <p>(2)褲款前幅有八字形花邊的款式,以高波計低於(包括)2.5CM的統一吊落車.Hang & attach to sew by folder for splay shape on front panel,height less than 2.5CM,including 2.5CM,measured high scallop</p> <p>(3)如客人有特別要求花波需對稱及高波計2.5CM以上的統一出紙樣Make pattern if guest require lace symmethic or height more than 2.5CM</p>
圖1. 款式圖	
圖2. 統一以下內容	<p>(1)單/雙波花邊封度高波至高波是4CM之內的款用筒吊落車.Hang & attach to sew by folder for single or double scallop, height between high scallop within 4CM</p> <p>(2)褲款前幅有八字形花邊的款式,以高波計低於(包括)2.5CM的統一吊落車.Hang & attach to sew by folder for splay shape on front panel,height less than 2.5CM,including 2.5CM,measured high scallop</p> <p>(3)如客人有特別要求花波需對稱及高波計2.5CM以上的統一出紙樣Make pattern if guest require lace symmethic or height more than 2.5CM</p>
備注說明 Remarks:	<p>註明:如客人有特別要求花波需對稱及高波計2.5CM以上的統一出紙樣</p> <p>Make pattern if guest require lace symmethic or height more than 2.5CM</p>



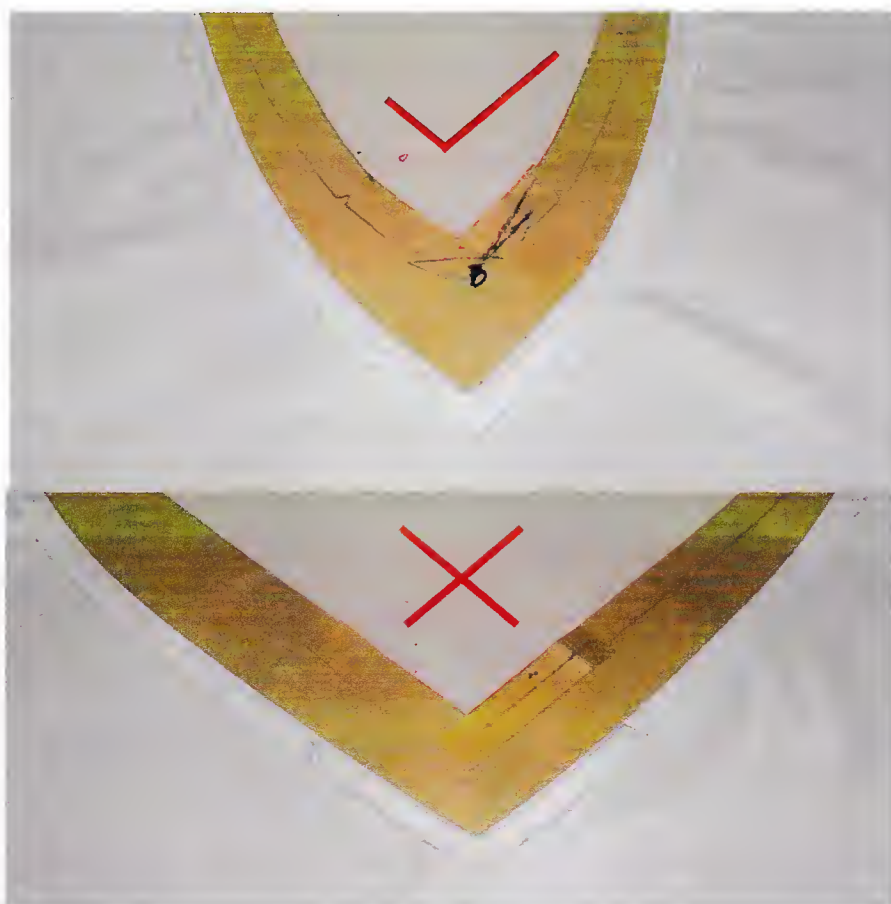
合隆技術標準指引

HopLun Technical standard direction

標準概述:	V型部位要加一小塊貼的紙格做法
Standard summarise :	Increase a small pattern for V-shape
執行日期:	2017年8月16日
Term of expiration date:	16-Aug-17
跟進人員:	紙樣組/辦房車間/大货技术员
Follow-up staffs:	Pattern/Workshop/Technician
標準說明:	
Standard explanation :	

V型部位要加一小塊貼的,現在紙樣師傅出的那一小塊貼有出頭尾要小點的,也有出頭尾大小一樣的.見下圖.現在統一跟圖一做法.出頭尾要小點的.統一此種款式做小塊貼頭尾要出小點的,完成后不可外露止口.

For V-shape needed a small pattern, some pattern maker make small start & end, some pattern maker make start & end the same. Unify that make small start & end and seam allowance invisible after finish

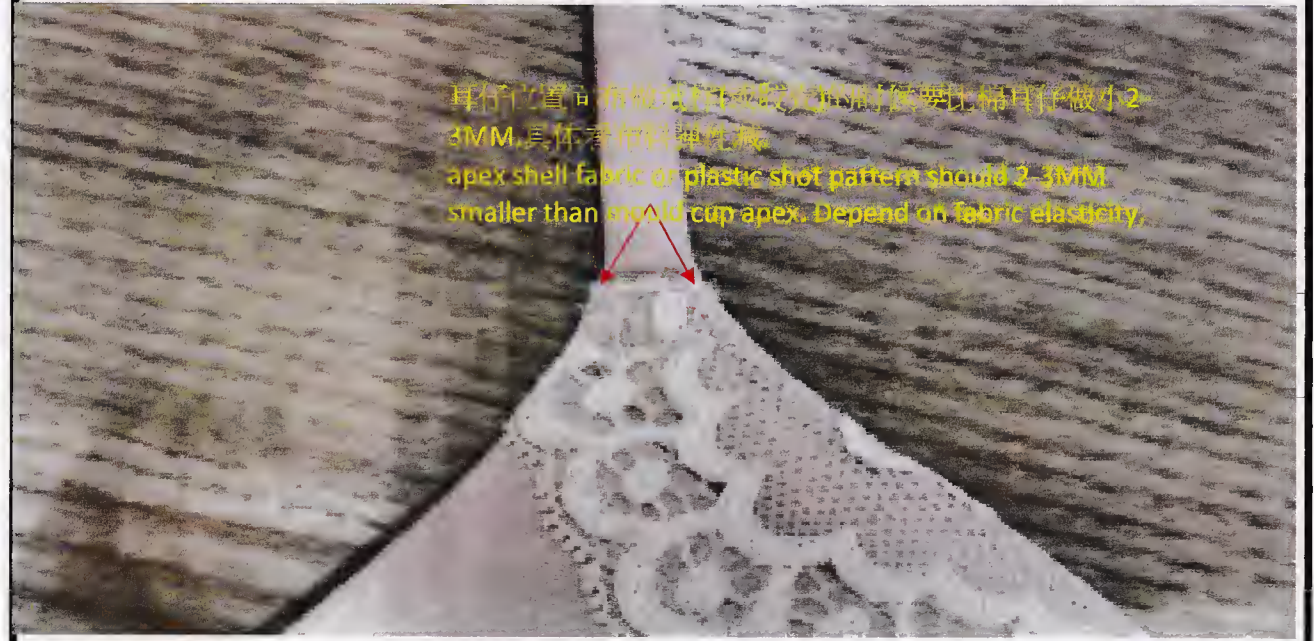


備注說明 Remarks:



合隆技術標準指引

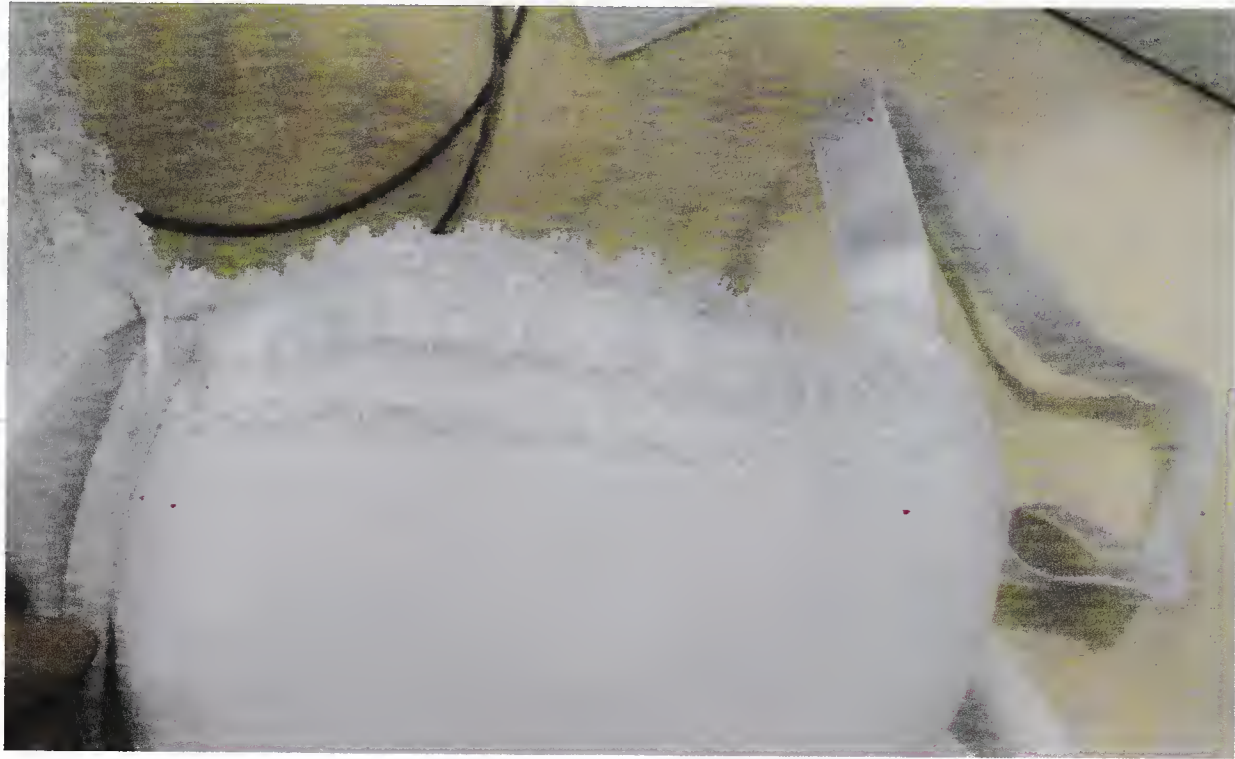
HopLun Technical standard direction

標準概述:	杯边和夹弯都是运反耳仔位纸样做法
Standard summarise :	Pattern of cup apex
執行日期:	2018年5月9日
Term of expiration date:	9-May-18
跟進人員:	模杯组/纸样组/辦房車間/大货技术员
Follow-up staffs:	Mould cup/Pattern/Workshop/Technician
標準說明:	
Standard explanation :	<p>杯边和夹弯都是运反打枣是密锁枣的款式,面布纸样(或胶壳)要比棉杯耳仔做小2-3MM,具體看布料彈性,完成面杯耳仔位不可松,要緊點.</p> <p>Front neckline and armhole are bagged out with densely bartack , shell fabric pattern or plastic shot pattern should 2-3MM smaller than mould cup apex. Depend on fabric elasticity, cannot loose after finish.</p>
	
備注說明 Remarks:	



合隆技術標準指引

HopLun Technical standard direction

標準概述:	杯邊丈根要穿跳孔的款式.
Standard summarise :	Neckline elastic cross interval hole on shell fabric
執行日期:	2017年3月29日
Term of expiration date:	29-Mar-17
跟進人員:	紙樣組/辦房車間/工藝組
Follow-up staffs:	Pattern /Workshop /Technology
標準說明:	
Standard explanation :	<p>模杯款杯邊有彈力的丈根要穿跳孔的款式(見圖1),紙樣師傅需要按膠殼裁樣給杯邊丈根剪長尺寸.</p> <p>For the style of neckline elastic cross interval hole on shell fabric with mould cup, pattern maker should offer elastic cutting size according to plastci shot cut pattern</p>
圖1. 款式圖	
Style sketch	
備注說明 Remarks:	

HopLun Technical standard direction

標準概述:	編結款紙樣畫結圈標準
Standard summarise :	Pattern standard about ring forming for knit styles
執行日期:	2017年3月15日
Term of expiration date:	15-Mar-17
跟進人員:	紙樣組/辦房車間/工藝組
Follow-up staffs:	Pattern Team/Workshop in sample room/Technology tea
標準說明:	
Standard explanation :	

統一(見圖2)所有編結款紙樣師傅要在紙樣上畫上結圈。

Unify that pattern maker must draw ring forming on pattern for all knit styles

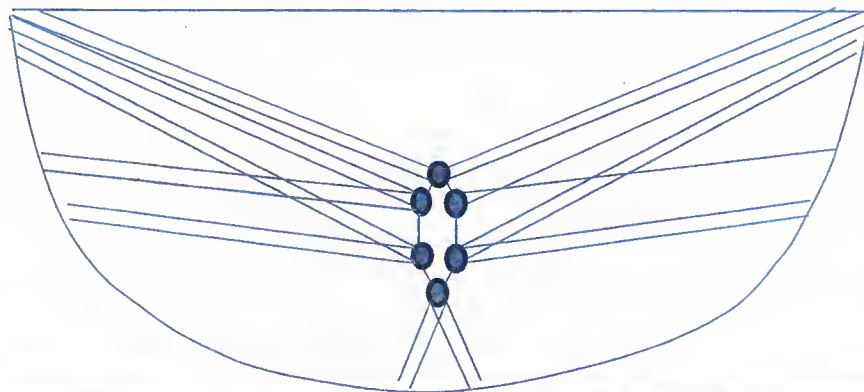
圖1. 款式圖

Sketch1. style sketch



圖2. 所有編結款紙樣師傅要在紙樣上畫上結圈。

Sketch2. pattern maker must draw ring forming on pattern for all knit styles



備注說明 Remarks:



合隆技術標準指引

HopLun Technical standard direction

標準概述:	驳比款纸样要求拉长后比要合适
Standard summarise :	Requirement of join wing pattern
執行日期:	2018年5月9日
Term of expiration date:	9-May-18
跟進人員:	纸样组/辦房車間/大货技术员
Follow-up staffs:	Pattern/Workshop/Technician
標準說明:	
Standard explanation :	

1:例如下图070-AA-00089款驳比纸样要求拉长后比5MM车,导致比完成变形,不合理.紙樣師傅要留意,不可拉太多,要看實際情況拉長.如此款拉2-3MM就可.

Take 070-AA-00089 for example, pattern maker require to stretch 5MM to sew after joining wing, cause back wing out of shape after finish which is unreasonable. Pattern maker should pay attention not stretch too much.For this style,just stretch 2-3MM will be OK.



備注說明 Remarks:

HopLun Technical standard direction

標準概述:	吊落丈根在布上的紙樣做法
Standard summarise :	Pattern of hang & attach elastic on fabric
執行日期:	2017年8月2日
Term of expiration date:	2-Aug-17
跟進人員:	紙樣組/辦房車間/大货技术员
Follow-up staffs:	Pattern/Workshop/Technician
標準說明:	
Standard explanation :	

統一所有面吊落丈根在布身上的款式,丈根底不可做空布,紙樣要出用及骨拼接起來后再吊落丈根.(註:如遇丈根太寬的款式,請提出討論后看實際情況決定做法.)

For styles of hanging & attaching elastic on fabric, elastic bottom should on fabric. pattern join fabric by OL first and then hang&attach elastic(decide the method depend on actual situation if elastic's too wide)



備注說明 Remarks:

標準概述:	鋼圈虛位算法標準
Standard summarise :	Calculate wire play
執行日期:	2016年11月10日
Term of expiration date:	10-Nov-16
跟進人員:	紙樣組/辦房車間/工藝組
Follow-up staffs:	Pattern Team/Workshop in sample room/Technology tea

標準說明:

Standard explanation :

所有順綑/倒綑碗款式(見圖1),統一鋼圈虛位算法:綑碗長減去鋼圈長再減去兩邊(打棗線距邊,棗長2MM+棗線邊距邊2MM)各4MM等於鋼圈虛位尺寸。(見圖2)

For all styles of seam allowance of upper cup towards front underbust or cup,unify the calculation of wire play:wire casing length-wire length-4mm on each side (2mm bartack length,2 mm from edge to edge)

圖1. 款式圖

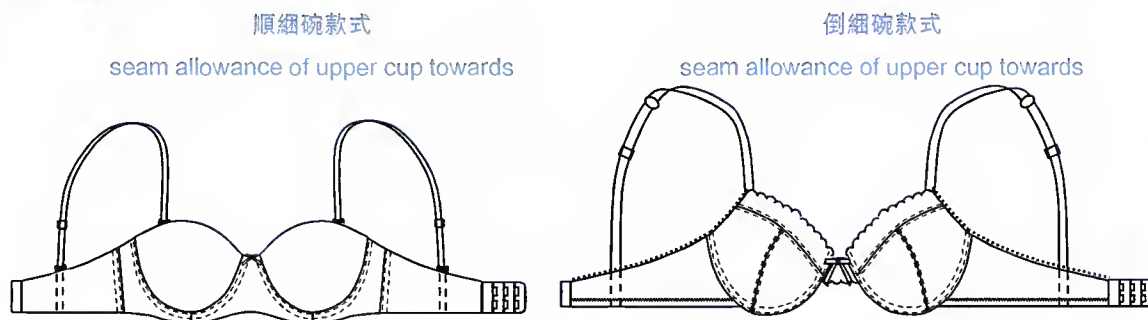
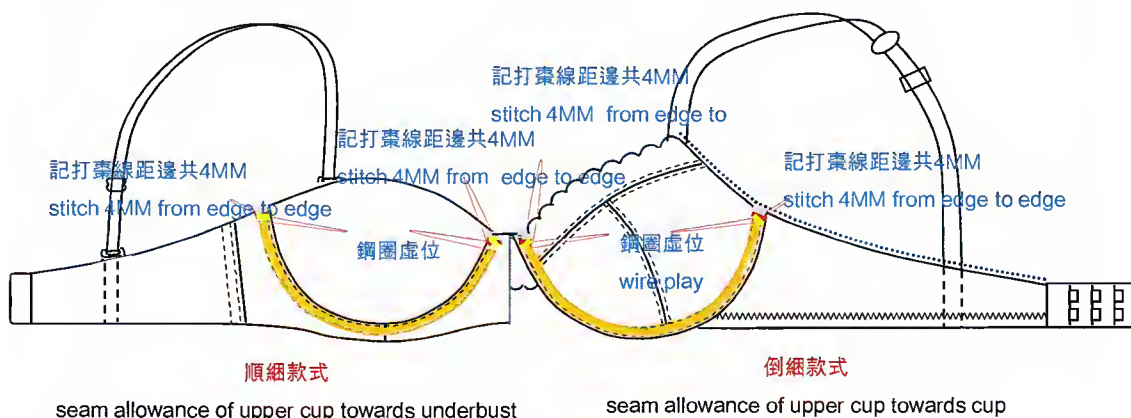


圖2. 統一鋼圈虛位算法:綑碗長減去-鋼圈長-再減去兩邊(打棗線距邊,棗長2MM+棗線邊距邊2MM)各4MM-等於=鋼圈虛位尺寸.

wire play=wire casing length-wire length-4mm on each side (2mm bartack length,2 mm from edge to edge)



備注說明 Remarks:

鋼圈虛位算法由各組技術員傳達給紙樣組長.如还有不明的請找Winnie 師傅沟通.

Technician pass the caculation to pattern leader, communicate with Winnie if still confused

標準概述:	勾圈位與丈根或細條封度的搭配
Standard summarise :	Match of H&E with elastic or binding
執行日期:	2018年5月9日
Term of expiration date:	9-May-18
跟進人員:	跟單組/紙樣組/辦房車間/大貨技術員
Follow-up staffs:	Merchandising/Pattern/Workshop/Technician
標準說明:	
Standard explanation :	
一:款式做法(見下圖)	
Styel sketch	
	
二.統一勾圈位與丈根或細條封度的搭配	Match of H&E with elastic or binding
<p>1:出細條內包丈根的款式,細條布料厚的,細條完成出口要比勾圈小1MM.細條布料薄的,細條完成出口要與勾圈一樣大. For binding wrap elastic, finished binding width IMM less than H&E for thick fabric, finished binding width be the same with H&E for thin fabric</p>	
	
<p>2:光身丈根與勾圈封度要一樣大.</p>	
<p>Plain elastic width should be the same with H&E</p>	
	
備注說明 Remarks:	
<p>建議在板單上特別註明,讓跟單通知定大料的供應商控制好來料的公差,(公差要求:勾圈与丈根都只能做正公差,公差要控制在1MM.)(案例,009-AA-00082款)</p>	
<p>Advice remark on sample order that merchandiser should inform supplier to control the tolerance within 1MM, just plus tolerance (example.009-AA-00082)</p>	

標準概述:	後肩帶花邊位紙樣及車縫做法
Standard summarise :	Paper pattern and sewing at back strap lace
執行日期:	2016年7月1日
Term of expiration date:	1-Jul-16
跟進人員:	紙樣組/辦房車間/工藝組
Follow-up staffs:	Pattern Team/Workshop in sample room/Technology tea

標準說明:

Standard explanation :

後肩帶中間位,是破開兩塊裁片的,中間位是先及骨後凹車落丈根襟骨(見圖1),統一以下
 2 cut piece on the middle of back shoulder strap,first OL,then CS attach & topstitch elastic, unify following:

- 1.中間位要用級骨車縫. OL sew middle part
- 2.紙樣要注意丈根分級,在耳仔位紙樣要跳碼,要做左右兩塊紙樣,左右紙樣的寬度是不一樣大的.(見圖2)

Pattern maker should pay attention to elastic grade, grade at apex on pattern, and draw right & left pattern with different width.

圖1. 款式圖

Style sketch



圖2.統一1:中間位要用級骨車縫.2:紙樣要注意丈根分級,在耳仔位紙樣要跳碼,要做左右兩塊紙樣,左右紙樣的寬度是不一樣大的.1.OL sew middle part 2.Pattern maker should pay attention to elastic grade, grade at apex on pattern, and draw right & left pattern with different width.



備注說明 Remarks:

HopLun Technical standard direction

標準概述:	雞心側比有絲帶或丈根的款式要加牛油紙紙樣
Standard summarise :	Increase butter paper patter for the styles with ribbon or elastic at gore or side seam
執行日期:	2015年10月1日
Term of expiration date:	1-Oct-15
跟進人員:	紙樣組/辦房車間/工藝組
Follow-up staffs:	Pattern Team/Workshop in sample room/Technology tea

標準說明:

Standard explanation :

1:凡雞心側比等有絲帶或丈根的款式(見圖1),統一增加牛油紙紙格.并在牛油紙上註明型號,牛油紙物料型號=036,工廠需要打嗲架紙去裁,麥架紙上需有型號.(見圖2)

For styles with ribbon or elastic at gore or side seam, unify that increase butter paper pattern and remark the NO. on it. The butter paper NO. is 036. Factories need cut according to marker with material NO.

2:關於牛油紙板單,要通知跟單在板單上增加此物料.

Inform mechandiser to add butter paper on sample order

圖1. 款式圖

Style sketch

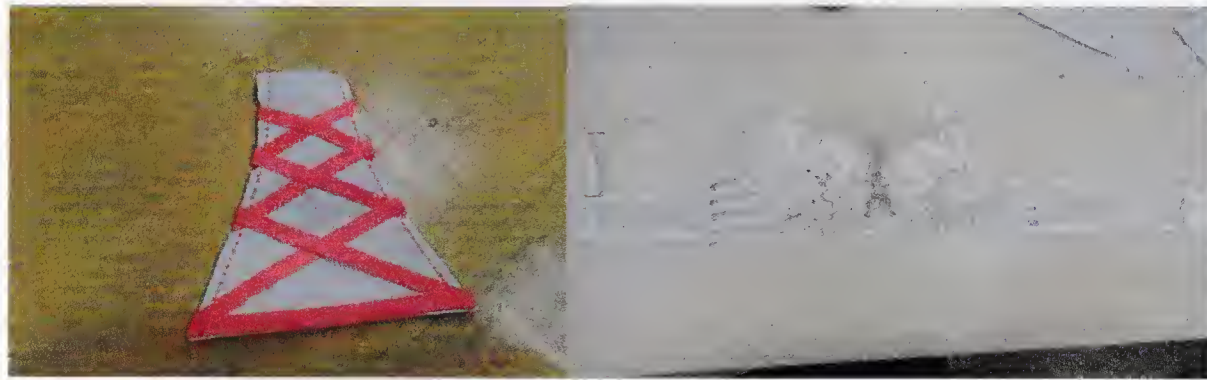


圖2. 牛油紙紙樣

Butter paper pattern



備注說明 Remarks:

關於牛油紙板單,要通知跟單在板單上增加此物料.

Inform mechandiser to add butter paper on sample order

標準概述:	雞心底定型紗不破骨
Standard summarise :	Fixed net inside gore not cut seam
執行日期:	2016年1月1日
Term of expiration date:	1-Jan-16
跟進人員:	紙樣組/辦房車間/工藝組
Follow-up staffs:	Pattern Team/Workshop in sample room/Technology tea
標準說明:	
Standard explanation :	
<p>雞心底有定型紗的(見圖1),統一所有雞心紗中間位不破骨.(見圖2)</p> <p>For the styles of fixed net inside gore, unify that no cut seam in the middle of the fixed net</p>	
<p>圖1. 款式圖</p> <p>Style sketch</p>	
<p>圖2. 統一雞心紗中間位要做不破骨</p> <p>No cut seam in the middle of the fixed net</p>	
備注說明	Remarks:



合隆技術標準指引

HopLun Technical standard direction

標準概述:	雞心網內定型紗封度
Standard summarise :	Fixed net width inside gore binding
執行日期:	2016年1月1日
Term of expiration date:	1-Jan-16
跟進人員:	紙樣組/辦房車間/工藝組
Follow-up staffs:	Pattern Team/Workshop in sample room/Technology tea
標準說明:	
Standard explanation :	
<p>雞心是細條的款式(見圖1)，統一所有客從新單開始雞心內定型紗用雙層，完成對折.例如細條出口10MM ,面網條用27MM,底網定型紗要用20MM.(完成如圖2)</p> <p>For the gore is binding, unify that fixed net inside gore binding should be double layer and folded after finishing for all customer from now on. For example, binding width is 10MM, shell binding should be 27MM, bottom fixed net binding should be 20MM</p>	
圖1. 款式圖	
Style sketch	
圖2. 雞心內定型紗用雙層(對折車).例如細條出口10MM ,面網條用27MM,底網定型紗要用20MM	
Fixed net inside gore binding should be double layer and folded after finishing . For example, binding width is 10MM. shell binding should be 27MM. bottom fixed net	
備注說明 Remarks:	

標準概述: 雞心中間破骨或V型底要用牛油紙的加中心線

Standard summarise : Add centerline on butter paper

執行日期: 2018年3月22日

Term of expiration date: 22-Mar-18

跟進人員: 紙樣組/辦房車間/大货技术员

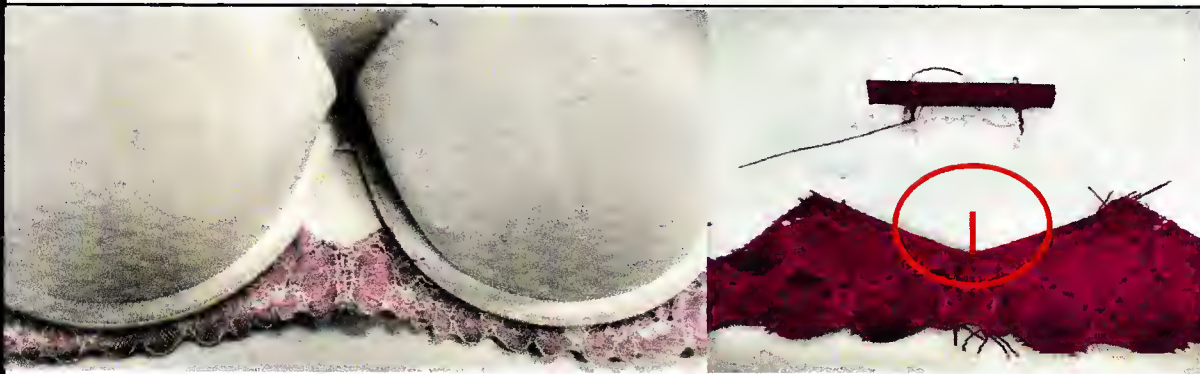
Follow-up staffs: Pattern Team/Pattern Team/Technician

標準說明:

Standard explanation :

統一雞心中間破骨或V型底要用牛油紙的款,在牛油紙中心位加一條中心參考線.(見下圖)

For cutting seam on middle of gore or V-shape bottom needed butter paper, unify that add a centerline in the middle of butter paper



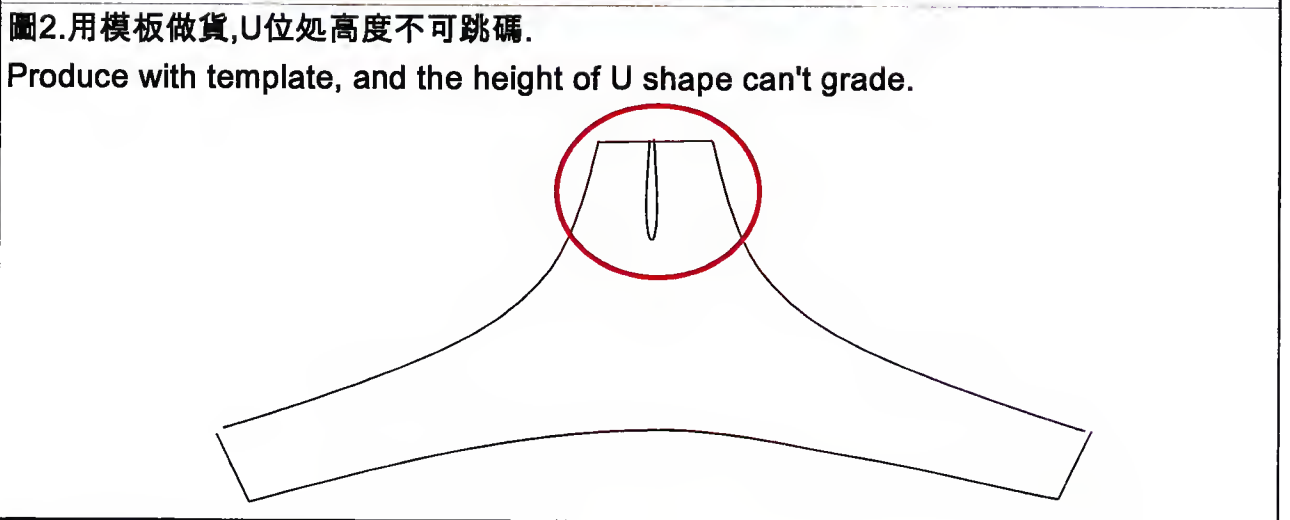
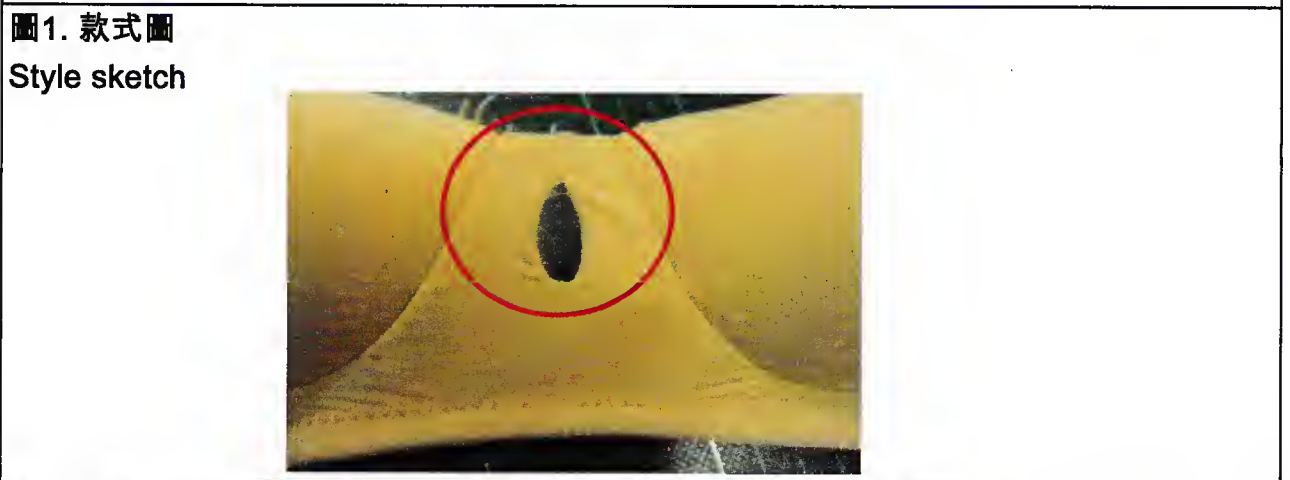
增加中心線
add a centerline

備注說明 Remarks:

標準概述:	雞心中做U位用模板做貨,U位高度不可跳碼
Standard summarise :	Produce CF U shape with template,height of U shape can't grade
執行日期:	2015年3月
Term of expiration date:	1-Mar-15
跟進人員:	紙樣組/辦房車間/工藝組
Follow-up staffs:	Pattern Team/Workshop in sample room/Technology tea

標準說明:	
Standard explanation :	

雞心中做U位的(見圖1),統一用模板做貨,U位处高度不可跳碼.(見圖2)
CF with U shape, unify that produce with template, and the height of U shape can't grade.



備注說明 Remarks:	
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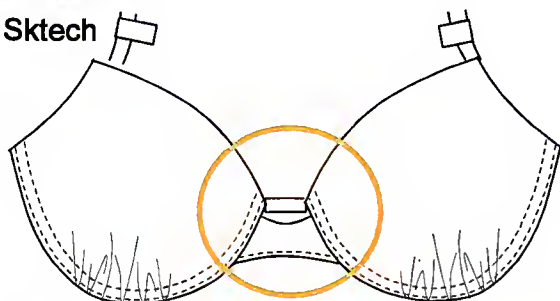
標準概述:	鷄心加牛油紙紙樣
Standard summarise :	Increase butter paper pattern on the gore
執行日期:	2016年1月1日
Term of expiration date:	1-Jan-16
跟進人員:	紙樣組/辦房車間/工藝組
Follow-up staffs:	Pattern Team/Workshop in sample room/Technology tea
標準說明:	
Standard explanation :	

鷄心分上下的款,上鷄心細+下車鷄心(見圖1), 統一增加鷄心牛油紙紙樣.(見圖2)

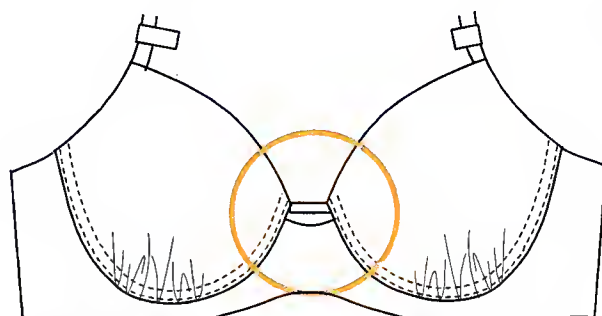
For the gore with binding on top and piece on bottom, unify that increase butter paper pattern on it.

圖1. 款式圖

Style Sktech



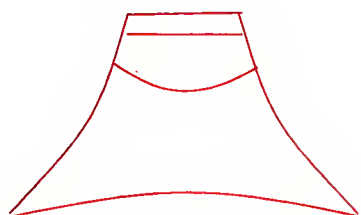
此類款式鷄心增加牛油紙紙樣,將上下鷄心車到牛油紙上再上碗。
Increas butter paper pattern on gore, sew top & bottom gore on butter paper pattern, and then join cup with wings



此類款式鷄心增加牛油紙紙樣,將上下鷄心車到牛油紙上再上碗.此款式下雞心牛油紙以空位最低點往下出1.5CM就可以了
Increas butter paper pattern on gore, sew top & bottom gore on butter paper pattern, and then join cup with wings. Make 1.5CM from the lowest point of the vacancy for bottom gore

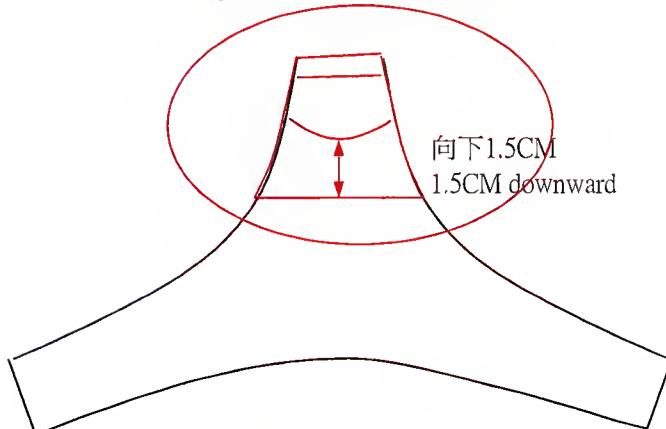
圖2. 牛油紙紙樣

Butter paper pattern



紅色線部分代表牛油紙

The red line on behalf of butter


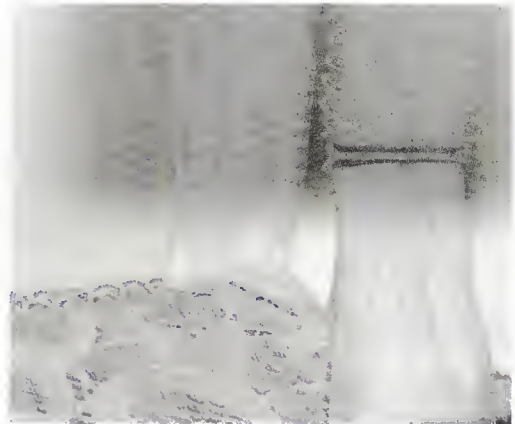




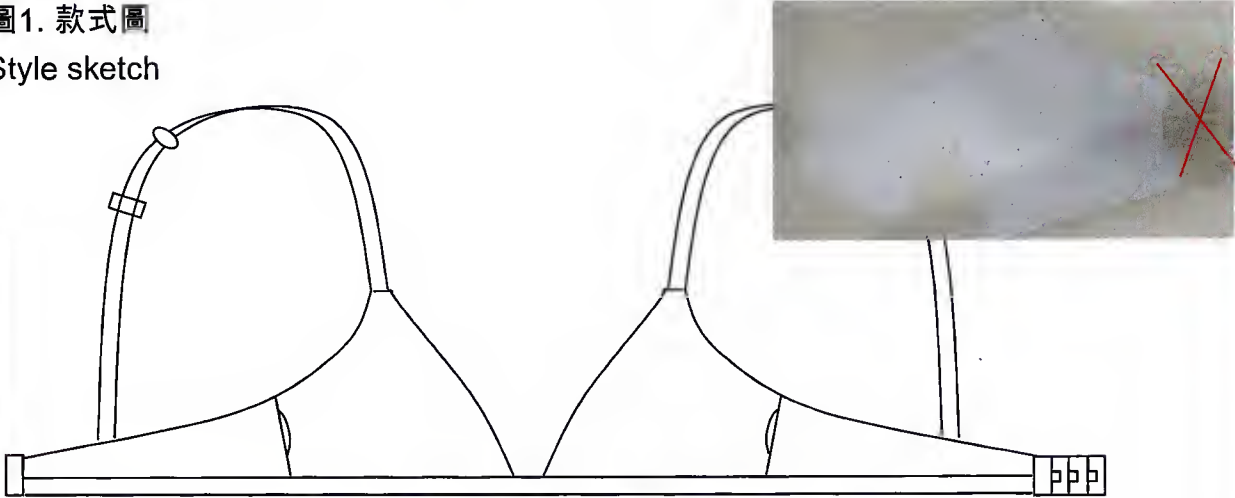
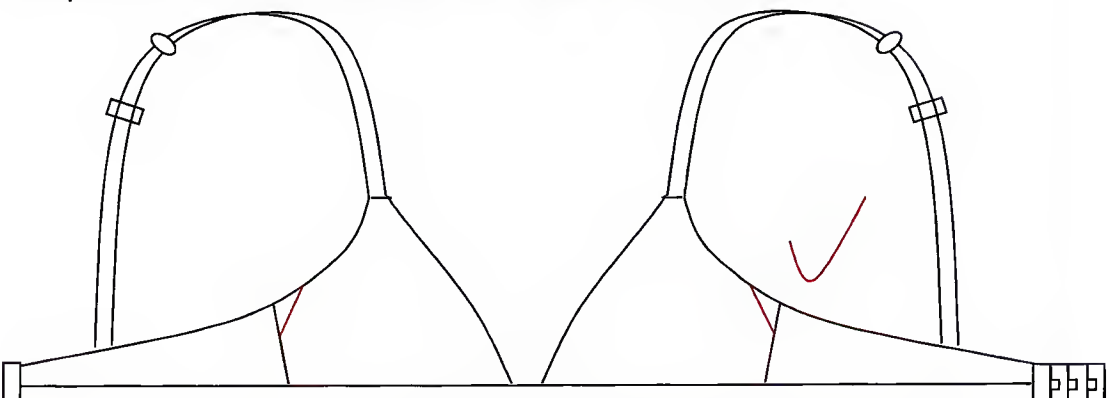
向下1.5CM
1.5CM downward

備注說明 Remarks:

HopLun Technical standard direction

標準概述:	浪底扣纸样做法
Standard summarise :	Pattern of button at gusset bottom
執行日期:	2018年5月9日
Term of expiration date:	9-May-18
跟進人員:	跟單組/紙樣組/辦房車間
Follow-up staffs:	Merchandising/Pattern/Workshop
標準說明:	
Standard explanation :	
見下圖要車浪底扣款式.	
Style need sew button at gusset bottom as followed	
	
統一浪底扣纸样上要画扣位置.包含间距尺寸也要准确,見下圖紙樣做法. Draw button location on pattern, including gap between them. Follow below pattern	
	
備注說明 Remarks:	

標準概述:	前肩帶是兩層布的款式要求
Standard summarise :	Requirement of 2 layer fabric on front shoulder strap
執行日期:	2016年8月
Term of expiration date:	1-Aug-16
跟進人員:	紙樣組/辦房車間/工藝組
Follow-up staffs:	Pattern Team/Workshop in sample room/Technology tea
標準說明:	
Standard explanation :	
<p>前肩帶是兩層布且兩層布一樣大的款式.(見圖1),統一面布要出細條,能出細條的盡量出細條,可以用反帶車提高效率.(見圖2)</p> <p>2 layer fabric and the same size on front shoulder strap, unify that fabric should make biding, make binding as far as possible</p>	
<p>圖1. 款式圖</p> <p>Style sketch</p> <div data-bbox="132 960 729 1384" data-label="Image">  </div> <div data-bbox="769 960 1279 1384" data-label="Image">  </div>	
<p>圖2 . 統一面布要出細條,(可以用反帶車提高效率)能出細條的盡量出細條.</p> <p>Fabric should make biding, make binding as far as possible</p> <div data-bbox="85 1493 694 1911" data-label="Image">  </div> <div data-bbox="701 1493 1329 1911" data-label="Image">  </div>	
備注說明 Remarks:	

標準概述:	統一內袋口開在側骨与夾彎之間
Standard summarise :	Cookie pocket mouth sewn between side seam and armhole
執行日期:	2017年3月29日
Term of expiration date:	29-Mar-17
跟進人員:	紙樣組/辦房車間/工藝組
Follow-up staffs:	Pattern Team/Workshop in sample room/Technology team
標準說明:	
Standard explanation :	
<p>有袋口的款(見圖1),統一所有袋口開在側骨与夾彎之間,做直袋口.如有客人特別要求就做弧型的,但是不可做直角袋口(見圖2)</p> <p>For the style witho cookie pocket, unify that all cookie pocket mouth sew between side seam and armhole with straight line, sew curve if guests have special requirements, but not right-angle pocket.</p>	
圖1. 款式圖	
Style sketch	
圖2.統一所有無客人要求款袋口開在側骨与夾彎之間.	
All cookie pocket mouth sew between side seam and armhole	
備注說明 Remarks:	



合隆技術標準指引

HopLun Technical standard direction

標準概述:	雙針底落紗筒19MM細條的針位要求.
Standard summarise :	Needle requirement for T/N lockstitch machine attach sablizer at bottom
執行日期:	2017年9月6日
Term of expiration date:	6-Sep-17
跟進人員:	紙樣組/辦房車間/大貨技術員/工藝員
Follow-up staffs:	Pattern/Workshop/Technician/Craft
標準說明:	
Standard explanation :	

統一雙針底落紗筒**19MM**寬度的細條，不同出口用不同的針位。
Different needle for different binding width of T/N lockstitch machine attach sablizer at bottom with 19MM binding
1:捆條出口**7MM**的,用**1/8"**雙針針位,用於車縫位置是平的,不用襟倒骨或開骨的做法用.(例如:襟雞心咀,捆、綑拼棉連接位等等...)**1/8" T/N sew flat position for binding width 7MM, no need topstitch seam or sew seam, for example, topstitch top gore.....**
2:捆條出口**8MM**的,用於**1/8"**雙針開骨或襟倒骨做法. **1/8" T/N sew seam or topstitch seam for binding width 8MM**
3:捆條出口**9MM**的用於**3/16"**雙針開骨或襟倒骨做法. **3/16" T/N sew seam or topstitch seam for binding width 9MM**


雙針托紗拉筒捆條表最新標 目錄 Content							
拉筒編號 CODE	車種 Machine	細條寬度 Width of binding	文巾寬度 Width of Elastic	出口寬度 Width of output	適用面料 Fabric	備註描述 Remarks	頁碼Page
11雙針底落紗筒FDNAE-double needle lockstitch machine attach stablizer(E-shaped)							
FDNAE1907	雙針DN	19MM	平	7MM	一般薄軟紗for soft net	適用於1/8"雙針托紗,車縫位置是平的,不用襟倒骨或開骨的做法用.(例如:襟雞心咀,捆拼棉連接位等等...) for 1/8" d/n attach binding to flat place, no need to topstitch seam or open seam (eg. attach to gore top, foam joint place.)	11-1-01
FDNAE2208	雙針DN	19MM	折	8MM	一般薄軟紗for soft net	適用於1/8"雙針開骨或襟倒骨托紗 For 1/8" d/n attach binding to open seam or topstitch seam	11-1-02
FDNAE1909	雙針DN	19MM	折	9MM	一般薄軟紗for soft net	適用於3/16"雙針開骨或襟倒骨托紗 For 3/16" attach binding to open seam or topstitch seam	11-1-05
2017/9/7日更新以上拉筒捆條表.							

備註說明 Remarks:



合隆技術標準指引

HopLun Technical standard direction

標準概述:	統一所有V位穿V型鋼圈做包邊網要用雙層定型紗.
Standard summarise :	Double layer fixed net inside wrapping binding
執行日期:	2018年3月22日
Term of expiration date:	22-Mar-18
跟進人員:	紙樣組/用量組/辦房車間/大貨技術員/工藝員
Follow-up staffs:	Pattern team/Unit
標準說明:	
Standard explanation :	
統一所有V位穿V型鋼圈做包邊網的.網條內定型紗要用雙層定型紗.	
All V-shape need insert V-shape wire and wrap binding, fixed net inside warpping binding should be double layer	
	
備注說明 Remarks:	



合隆技術標準指引

HopLun Technical standard direction

標準概述:	統一網布或花邊款勾圈位的紙樣出法
Standard summarise :	Pattern of H&E
執行日期:	2018年3月22日
Term of expiration date:	22-Mar-18
跟進人員:	跟單組/用量組/辦房車間/大貨技術員
Follow-up staffs:	Merchandising/Unit Consumption/Workshop/Technician

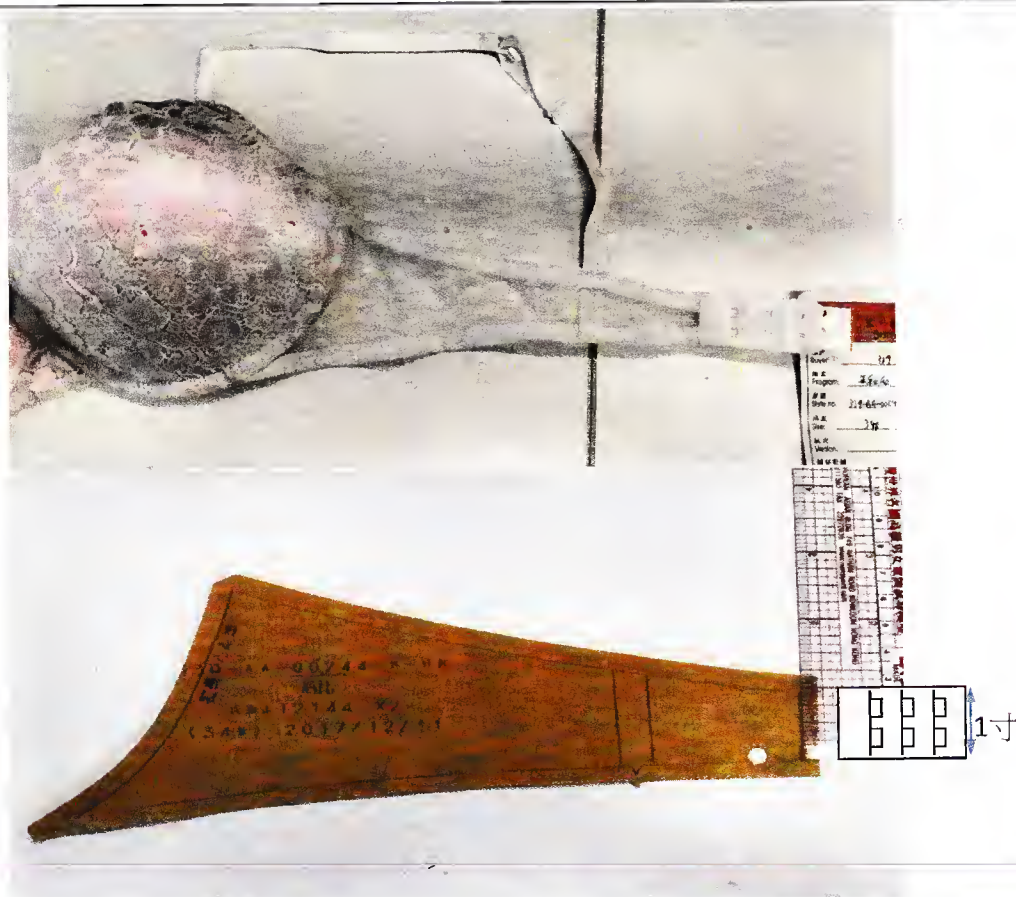
標準說明: Standard explanation :

統一網布或花邊款,上/下比兩邊都要拉三針的款式,按實際勾圈尺寸出紙格,再每邊加大1MM紙樣.

註:如遇網孔很大的布料,按實際情況加大子口.

For style with mesh or lace, 3 ZZ attach upper wing and lower wing elastic, should make pattern according to H&E's actual size, then increase 1MM pattern for each side

Remark:if meet fabric with big hole, increase seam allowance according to actual situation



備注說明 Remarks:



合隆技術標準指引

HopLun Technical standard direction

標準概述:	完成會縮水的款式要求
Standard summarise :	Requirement of shrinkage after finishing
執行日期:	2017年3月29日
Term of expiration date:	29-Mar-17
跟進人員:	紙樣組/辦房車間/工藝組
Follow-up staffs:	Pattern Team/Workshop in sample room/Technology tea
標準說明:	
Standard explanation :	

完成會縮水的款式,如燙片繡花(見圖1), 統一以下

For The style will shrink after finishing, such as panel pressing/embroidery, unify below:

1:大部位燙片/繡花需給完成實樣.小部位燙片縮水小於3MM的不用給完成實樣.

Need finish actual pattern for large shrinkage part of panel pressing/embroidery. No need for shrinkage less than 3MM

2:紙樣師傅要用大貨跟單提供的大貨料做測試後出完成實樣.(見圖2)

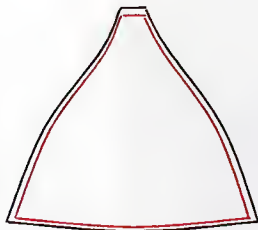
Pattern maker should make actual paper pattern ater test bulk material offered by merchandiser

圖1. 款式圖Style sketch

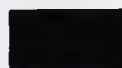


圖2.統一燙片/繡花會有縮水的款式1:大部位燙片的/繡花的都要給完成實樣.小部位燙片縮水小於3MM的不用給完成實樣.2:紙樣師傅要用大貨跟單提供的大貨料做測試後出完成實樣.

For The style will shrink after finishing, such as panel pressing/embroidery, unify below:1.Finish actual paper patterns for large part of panel pressing/embroidery. No need for shrinkage less than 3MM;2.Pattern maker should make actual pattern ater test bulk material offered by merchandiser



實樣綫
actual



裁樣綫

備注說明 Remarks:

已經郵件通知營業部大貨跟單要提供大貨料做測試後出完成實樣.

Inform merchandiser to offer buld material to test,and then make actual pattern

HopLun Technical standard direction

標準概述:	无弹力布料的钢圈围碗圈位纸样出法
Standard summarise :	Wire casing pattern for wire bra with inelastic fabric
執行日期:	2016年11月10日
Term of expiration date:	10-Nov-16
跟進人員:	紙樣組/辦房車間/工藝組
Follow-up staffs:	Pattern Team/Workshop in sample room/Technology tea
標準說明:	
Standard explanation :	

所有鋼圈圍，布料無彈力的款式(見圖1)，統一碗圈位的紙樣要在尺寸基礎上額外加大3MM,但尺寸要按正常算.(見圖2)

For all wire bra with inelastic fabric ,unify that wire casing pattern should add 3MM base on the size.Only add the pattern, the size remain original

圖1. 款式圖

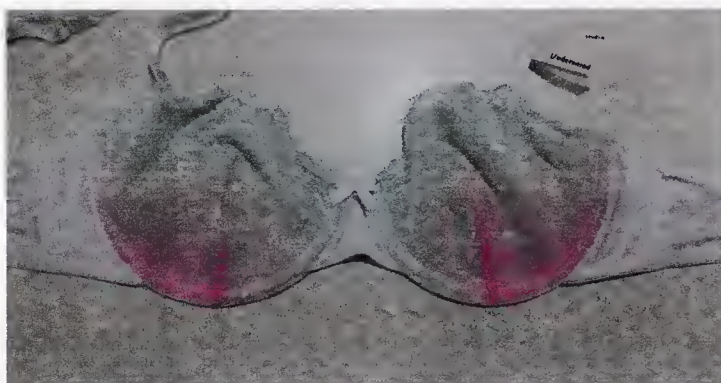
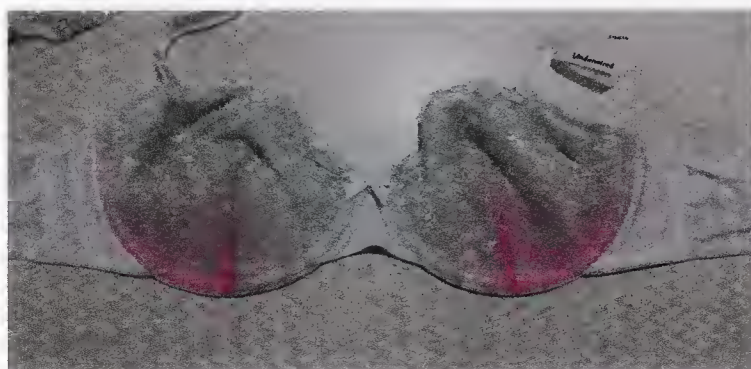


圖2.

統一(無彈力布料的钢圈围)碗圈位紙樣要在尺寸基礎上額外加大3MM,尺寸要按正常算.

all wire bra with inelastic fabric ,unify that wire casing pattern should add 3MM base on the size.Only add the pattern, the size remain original



備注說明 Remarks:

標準概述:	下雞心是寬丈根的做法
Standard summarise :	The method of Lower gore with wide elastic
執行日期:	2014年11月25日
Term of expiration date:	25-Nov-14
跟進人員:	紙樣組/辦房車間/工藝組
Follow-up staffs:	Pattern Team/Workshop in sample room/Technology tea

標準說明:

Standard explanation :

下雞心是寬丈根,丈根要用人字車吊落到上雞心面布上的做法(見圖1),統一上雞心面布出細條,丈根與細條一次性吊落後再交由裁床按實樣裁.(見圖2)

While lower gore is wide elastic which needs to attach to shell fabric of upper gore by ZZ, unify that make binding for upper gore shell fabric, hang & attach elastic with binding, and then pass to cutting tabel to cut according to actural paper pattern

圖1. 款式圖

Style sketch

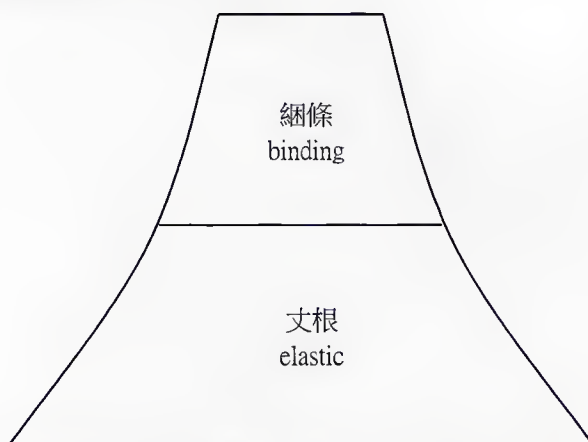
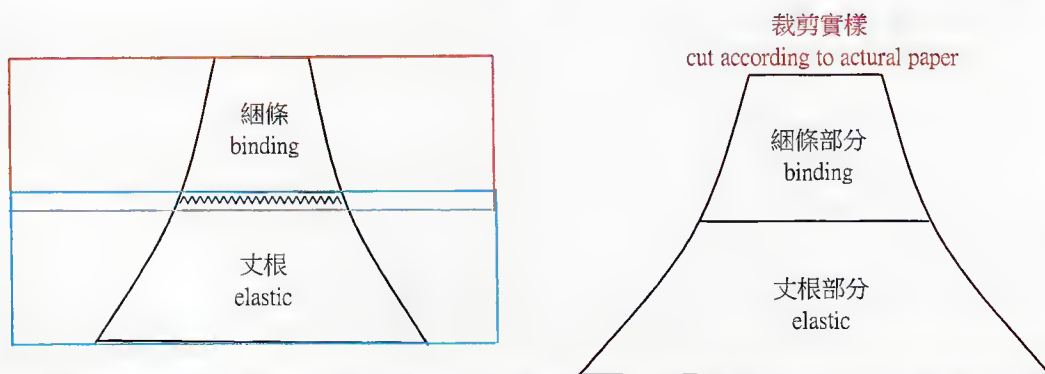


圖2. 丈根與捆條一次性吊落後再交由裁床按實樣裁.

Hang & attach elastic with binding, and then pass to cutting tabel to cut according to actural



備注說明 Remarks:

標準概述:	雞心腳尖位紙樣
Standard summarise :	Pattern of gore bottom tip
執行日期:	2016年1月
Term of expiration date:	1-Jan-16
跟進人員:	紙樣組/辦房車間/工藝組
Follow-up staffs:	Pattern Team/Workshop in sample room/Technology tea

標準說明:

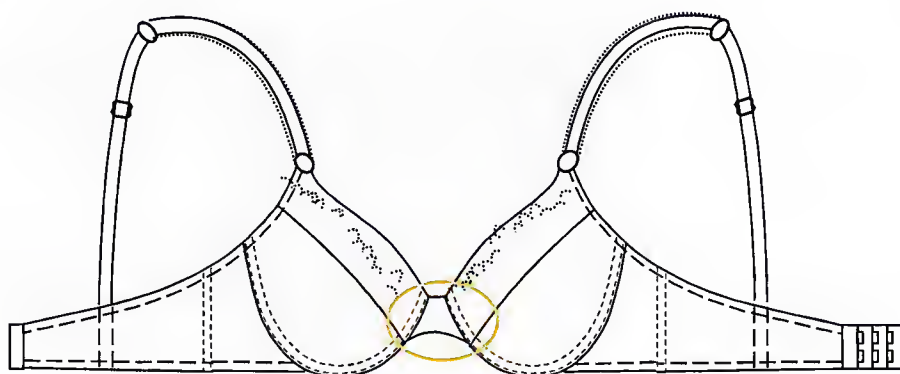
Standard explanation :

For the styles of gore without cradle(sketch1),unify that pattern of gore bottom tip can't be too slim and long(sketch2)

針對小雞心款(見圖1)；統一雞心腳尖位出紙樣時不可太細,太長.(見圖2)

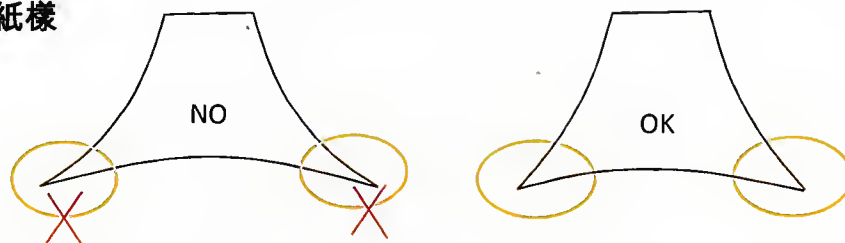
Sketch1. Style sketch

圖1 . 款式圖



Sketch2. Pattern of gore bottom tip

圖2.雞心腳尖位紙樣



Pattern of gore bottom tip can't be too slim and long

雞心腳尖位出紙樣時不可太細,太長.

Remarks:備注說明

The standard use for the styles of gore without cradle

此標準用於小雞心款式

HopLun Technical standard direction

標準概述:	新模杯資料格式范本
Standard summarise :	Update mould-cup information form
執行日期:	2017年7月3日
Term of expiration date:	3-Jul-17
跟進人員:	模杯組/紙樣組/辦房車間/大货技术员
Follow-up staffs:	Mould sample room/Pattern/Workshop/Technician
標準說明:	
Standard explanation :	

統一新模杯資料格式范本,見下圖.

Update the mould-cup information from as below

[illegible]

備注說明 Remarks:



合隆技術標準指引

HopLun Technical standard direction

標準概述:	要固高波的款式紙樣出法.
Standard summarise :	Pattern of fixing high scallop
執行日期:	2017年8月16日
Term of expiration date:	16-Aug-17
跟進人員:	紙樣組/辦房車間/大货技术员
Follow-up staffs:	Pattern/Workshop/Technician
標準說明:	
Standard explanation :	

花邊波型一樣,是循環的,要固高波的款式,統一在固波位紙格增加波型,平低波位置註明平低波要求.(見下圖標準)

Scallop shape of lace is the same and need fix high scallop, unify to increase scallop shape at scallop position needed fix and remark requirement at valley



備注說明 Remarks:

標準概述:	有下趴碗圈要駁杯,面杯是連側骨的模杯款式
Standard summarise :	Cup shell connect side wing, join cradel with inner cup
執行日期:	2017年3月15日
Term of expiration date:	15-Mar-17
跟進人員:	紙樣組/辦房車間/工藝組
Follow-up staffs:	Pattern Team/Workshop in sample room/Technology tea
標準說明:	
Standard explanation :	<p>有下趴碗圈要駁杯,面杯是連側骨的模杯款式(見圖1),統一在模杯尺寸上增加側骨完成尺寸包括齊碼尺寸、備註紙格需容多少.</p> <p>For the styles of cup shell connect side wing, join cradel with inner cup, unify that increase side seam finished size including full size,remark how many should pattern shrink</p>
圖1. 款式圖	
Sketch1. Style sketch	
備注說明 Remarks:	



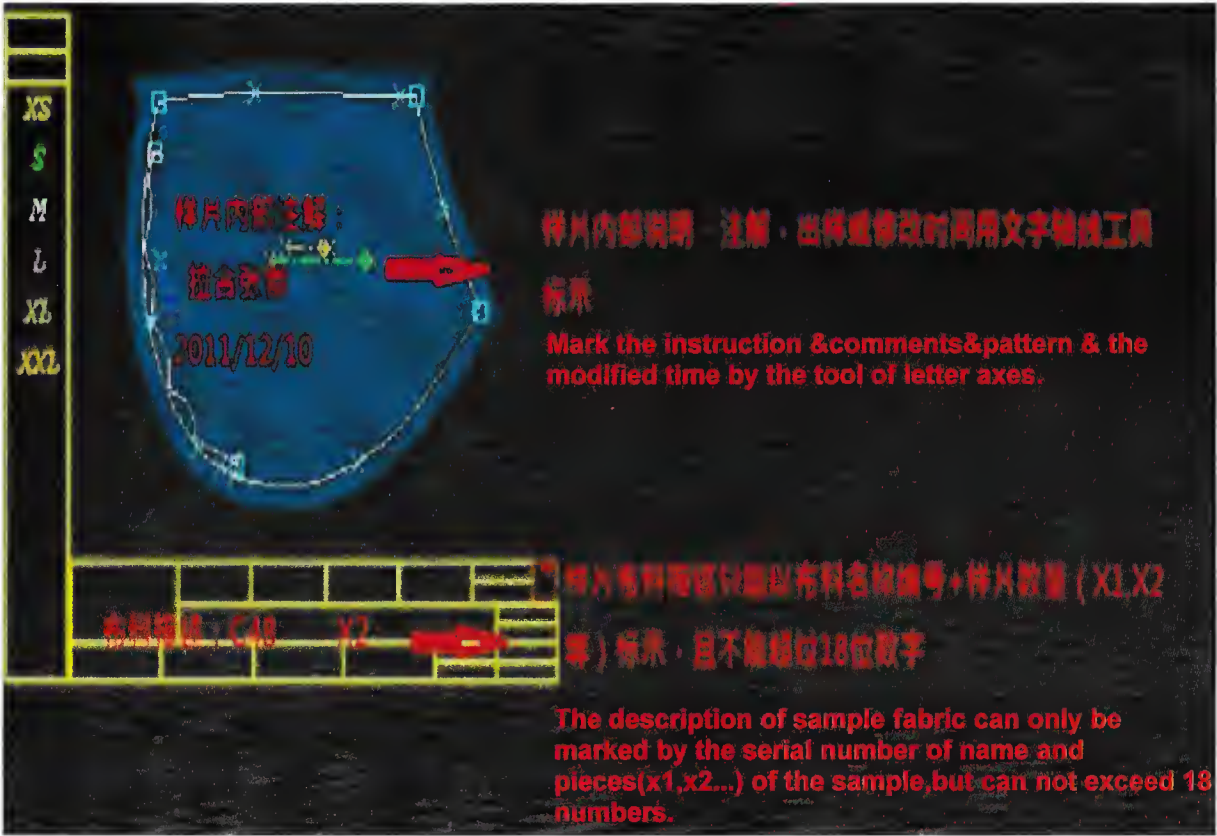
2、紙樣標準類 Pattern Standard

2-2、電腦紙樣製作 Computer pattern making

標準概述:	儲存力克檔案的注意事項
STANDARD BRIEF:	The Notice Of Saving Lectra Files
執行日期:	2011年12月15日
EXCUTION DATE:	15-Dec-11
跟進人員:	紙樣組長/核算組長
FOLLOW-UP STAFFS:	Pattern Team Leader / MU Team Leader

標準說明STANDARD EXPLANATION:

- 4. 樣片內部注解.
- .The comments on the sample.



樣片內部說明 注解，出樣或修改時間用文字軸線工具

標示

Mark the instruction & comments & pattern & the modified time by the tool of letter axes.

樣片布料描述以單以布料名稱編號+樣片數量 (X1,X2 等) 標示，且不能超過18位數字

The description of sample fabric can only be marked by the serial number of name and pieces(x1,x2...) of the sample, but can not exceed 18 numbers.

市標編號: C48	X2
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備注說明Remarks:



合隆技術標準指引

HopLun Technical standard direction

標準概述: STANDARD BRIEF:	力克電腦款式命名需統一 To Name The Lectra Computer Pattern Consistently.
執行日期: EXCUTION DATE:	2011年11月28日 28-Nov-11
跟進人員: FOLLOW-UP STAFFS:	紙樣組長/紙樣員 PatternTeam Leader/ Paper Patternner
標準說明STANDARD EXPLANATION: 正確的款式標準命名是由: 款號+級碼命名 The right pattern standard is named for :Style No. and Grade size No.	
<div>1. 當頭樣完成后, 存放在力克系統/紙樣文件夾的正確款式標準命名是: 款號+級碼命名 The correct pattern standard which reserve in the Lectra system / pattern document is named for style No. and grade size No. after first sample is finished .</div> <div><div>1) 正確例子Right case : 339-G-00094-A</div><div><div>款號</div><div>級碼命名</div></div></div>	
<div>2) 錯誤例子wrong case: 339-G-00094-A 10-07-27</div> <div>不需寫日期</div>	
<div>2. 在力克系統里的款式命名不統一, 將會導致單用量組重复排嘜的錯誤. The pattern denominate in Lectra system is different which will cause fault when the MU team deal with marker.</div>	
<div>3. 成衣檔案布料命名按附錄第1~2頁. garther file name according to page 1~2 in appendix.</div>	
備注說明Remarks:	



合隆技術標準指引

HopLun Technical standard direction

標準概述:	手工紙樣需与電腦紙樣完全吻合
STANDARD BRIEF:	Manual Pattern Should Be Consistent With Computer Pattern Perfectly.
執行日期:	2011年11月28日
EXCUTION DATE:	28-Nov-11
跟進人員:	紙樣組長
FOLLOW-UP STAFFS:	Pattren Team Leader
標準說明STANDARD EXPLANATION:	
<p>當第二次做辦需手工修改紙樣時, 也同時修改力克電腦系統的紙樣.需確保兩者完全吻合. 如果兩者不完全吻合, 會導致用量的錯誤.</p> <p>When need to mend paper pattern manually for doing samples secondly,pls at the same time modify paper pattern of Lectra computer system.Make sure they are matching perfectly.If not,it will cause fault about material usage .</p>	
備注說明Remarks:	



2、紙樣標準類 Pattern Standard

2-3、紙格信息 Pattern information

標準概述:	如何注明模杯內袋紙格
STANDARD BRIEF:	How To Mark The Paper Pattern Of Padded Cup's Inside Pocket
執行日期:	2011年4月6日
EXCUTION DATE:	6-Apr-11
跟進人員:	紙樣組長(模杯)
FOLLOW-UP STAFFS:	Pattern Team Leader

標準說明STANDARD EXPLANATION:

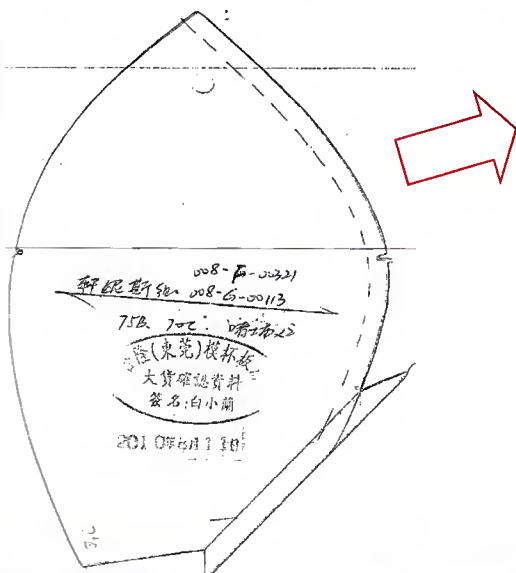
模杯有內袋的款式,需將內袋紙格頭樣復印一份訂在板單上(紙样須有止口线),以便各環節查詢。
If the padded cup has inside pocket, we need to copy its paper pattern and attach the copy on the order(the papper pattern should carry the drawing of allowance) for inquiry.

1.款式圖(Picture of style)



2.模杯內袋紙格的注明方式,如下圖所示:

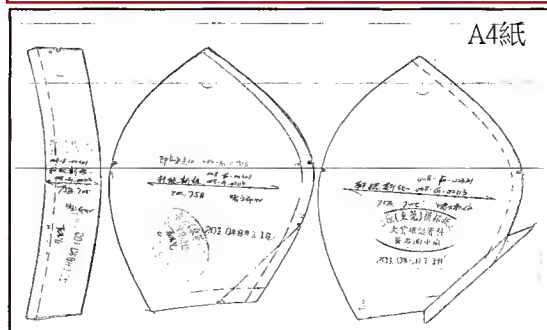
The way to sign the paper pattern ,such as the following picture.



第一步:A4紙復印紙格如左圖所示

Step1:Copy the pattern of inside pocket at A4 paper as left picture

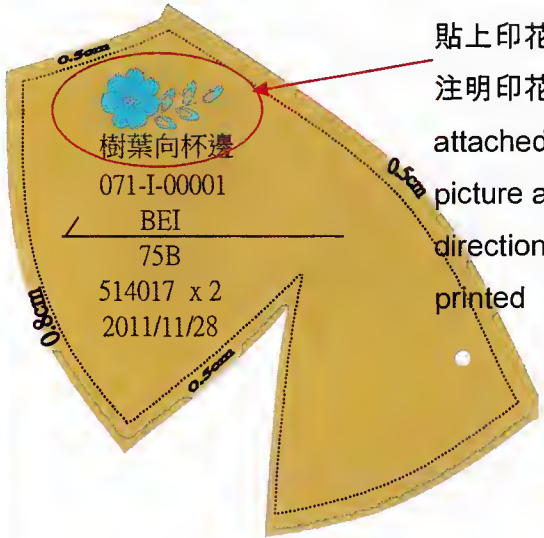
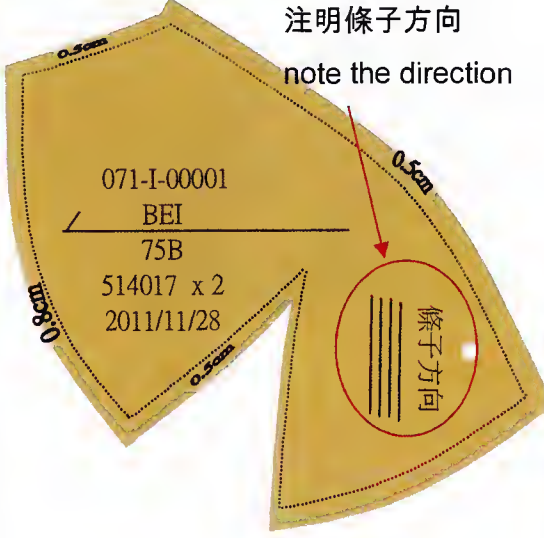
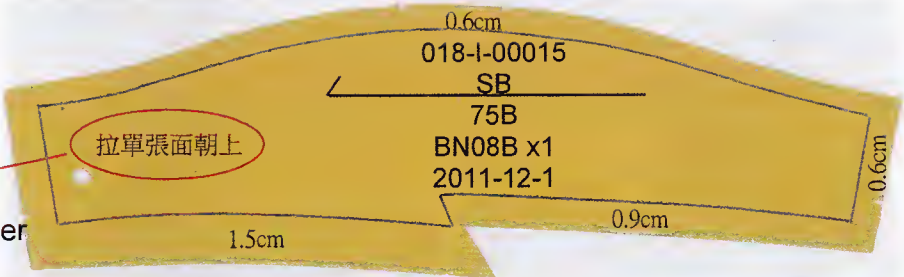
第二步:將A4紙附于板單上



此款共3片紙样(內袋)

Three pieces of papper in inside pocket.


備注說明Remarks:

標準概述:	印花紙格的標準信息
STANDARD BRIEF:	Standard Information On Paper Patterns Of Printed
執行日期:	2011年11月28日
EXCUTION DATE:	28-Nov-11
跟進人員:	紙樣組長
FOLLOW-UP STAFFS:	Pattern Team Leader
標準說明STANDARD EXPLANATION: 所有印花需注明印花方向,条子布要求條子方向,需单张排唛的也需特別注明。 For all the printed,the direction of printed should be marked on paper pattern,so do the stripped.Otherwise,it also needs to be specially noticed when arranging single-piece maker	
1.印花款紙樣Paper pattern of printed:  <p>貼上印花圖案及 注明印花方向 attached the picture and note direction of printed</p>	2.條子款紙樣Paper pattern of stripped:  <p>注明條子方向 note the direction</p>
3.单张排唛Single-piece maker planning:  <p>需注明单张排唛 note Single-piece marker planning</p>	
備注說明Remarks:	

標準概述: STANDARD BRIEF:	紙格上需注明的信息 Necessary Information Marks On The Papper Pattern
執行日期: EXCUTION DATE:	2011年11月28日 28-Nov-11
跟進人員: FOLLOW-UP STAFFS:	紙樣組長 Pattern team leader

標準說明STANDARD EXPLANATION:


700
750




同類代號: 參考字:

註解:

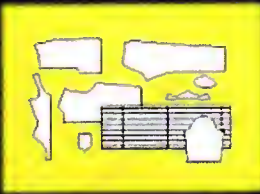
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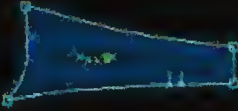
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款式件: 季節:

註解:


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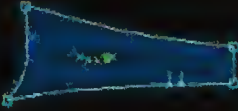
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950



備注說明Remarks:

編寫: 板房研發組

2018/12/27

2-3-3

標準概述:	壓折布紙格的標準信息
STANDARD BRIEF:	Standard Information Paper Patterns Of Pleated Show
執行日期:	2011年11月28日
EXCUTION DATE:	28-Nov-11
跟進人員:	紙樣組長
FOLLOW-UP STAFFS:	Pattern team leader

標準說明STANDARD EXPLANATION:

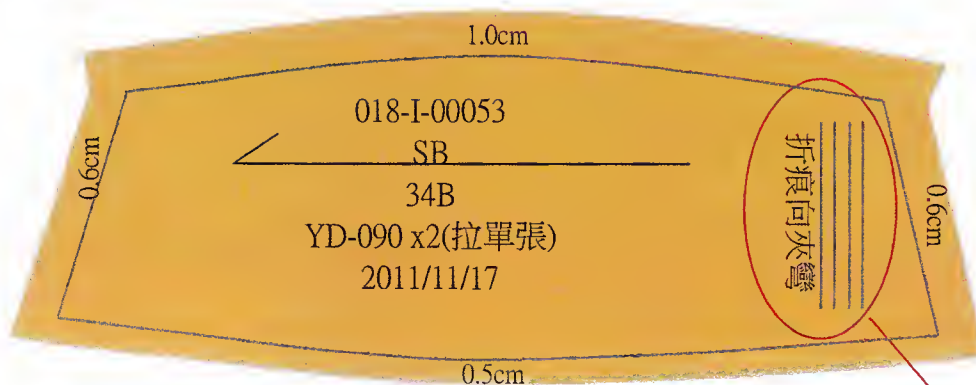
壓褶布如有壓褶倒向,紙樣需標示清楚.

.For all the pleated,the direction of flowing should be marked on paper pattern.

1.壓褶布款式圖 Pleated style:



2.壓褶款紙樣Paper pattern of pleated:



需注明壓褶倒向

Note the direction of
flowing

備注說明Remarks:



合隆技術標準指引

HopLun Technical standard direction

標準概述:	提供模杯圍內袋基碼紙格
STANDARD BRIEF:	Provide basic pattern of insided pocket for the mould cup bra
執行日期:	2013年4月24日
EXCUTION DATE:	24-Apr-13
跟進人員:	工藝組
FOLLOW-UP STAFFS:	Technology process team
標準說明STANDARD EXPLANATION:	
<p>模杯圍有內袋紙格款，模杯板房須提供更新正确的內袋基碼紙样復印件給工藝組存入留底资料中。</p> <p>If the mould cup with inside pocket, mould cup sample room need to provide copy basic pattern of the inside pocket which must be correct . Technology process team will keep it in office copy data.</p>	
備注說明Remarks:	



2、紙樣標準類

Pattern Standard

2-4、紙樣止口標準

Pattern seam allowance standard

標準概述:	使用鋼圈套的圖款的止口和針位要求
STANDARD BRIEF:	Rqts Of Allowance & Needle Distance Of Wire Casing
執行日期:	2011年6月20日
EXCUTION DATE:	20-Jun-11
跟進人員:	車間總指導/紙樣組長
FOLLOW-UP STAFFS:	Sewing Team Leader / Pattern Team Leader

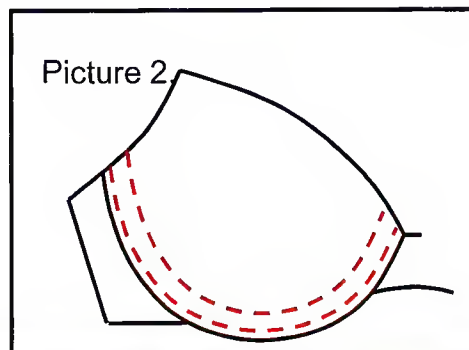
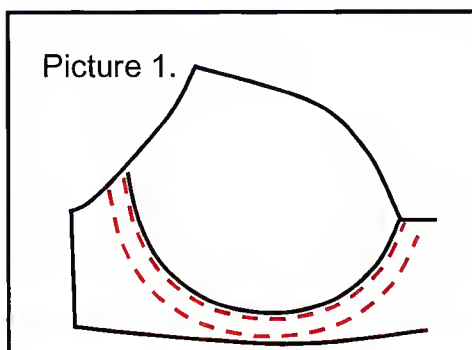
標準說明STANDARD EXPLANATION:

1. 棟比位 Side seam of position

鋼圈套寬度 wire casing width	針位 needle distance	車縫止口 sewing seam allowance
10mm	1/4"	8mm
11mm	5/16"	10mm

2. 網碗位 Wire channel of position

鋼圈套寬度 wire casing width	網碗方向 wire channel bearing	針位 needle distance	上碗時車縫止口 sewing seam allowance
10mm	順網 picture 1.	1/4"	8mm
	倒網 picture 2.	1/4"	杯位8mm 比位6mm
11mm	順網 picture 1.	1/4"	8mm
	倒網 picture 2.	1/4"	杯位8mm 比位6mm



備注說明Remarks:

泳衣類除外.

Except swimsuit category.

標準概述:	人字沿波車花止口
STANDARD BRIEF:	ZZ sew lace seam allowance along scallop
執行日期:	2015年3月26日
EXCUTION DATE:	26-Mar-15
跟進人員:	紙樣組長/車間
FOLLOW-UP STAFFS:	Paper pattern/ Sewing room
標準說明STANDARD EXPLANATION:	
<p>疊花邊人字沿波車花，車完花後需通花的款式.討論車一行人字線後通花需要留多大止口,紙樣出多少止口.車兩行人字線後通花需要留多大止口,紙樣出多少止口.(參考MMA15P2897款)</p>	
<div></div>	
備注說明Remarks:	
<p>疊花邊人字沿波車花後需要通花款.統一正常布料車一行人字線紙格出6MM止口,車兩行人字線紙格出10MM止口,通花距人字線留3MM止口.特殊布散絲料紙樣需增加備註.</p>	



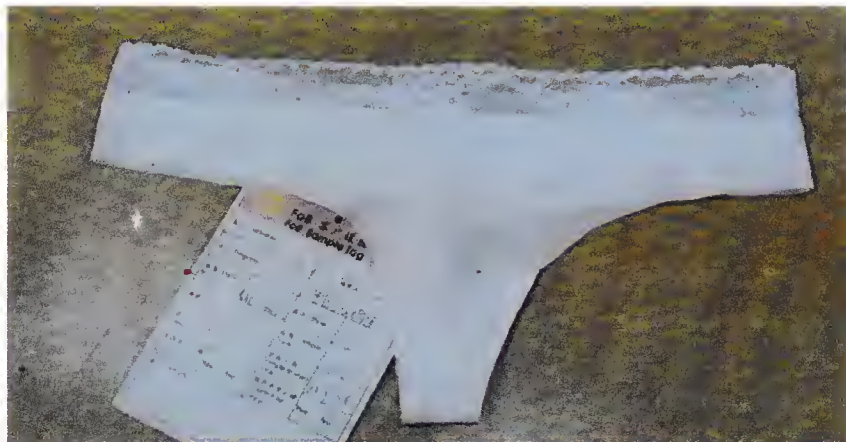
合隆技術標準指引

HopLun Technical standard direction

標準概述:	成品止口不外露
STANDARD BRIEF:	Seam allowance invisible for finished product
執行日期:	2013年10月22日
EXCUTION DATE:	22-Oct-13
跟進人員:	紙樣組長/紙樣技術員
FOLLOW-UP STAFFS:	Paper pattern/Technician

標準說明STANDARD EXPLANATION:

如圖里浪骨位紙格折回會有凸出尖角止口.類似款統一在出紙格時修掉尖角，確保成品后止口不外露。



備注說明Remarks:



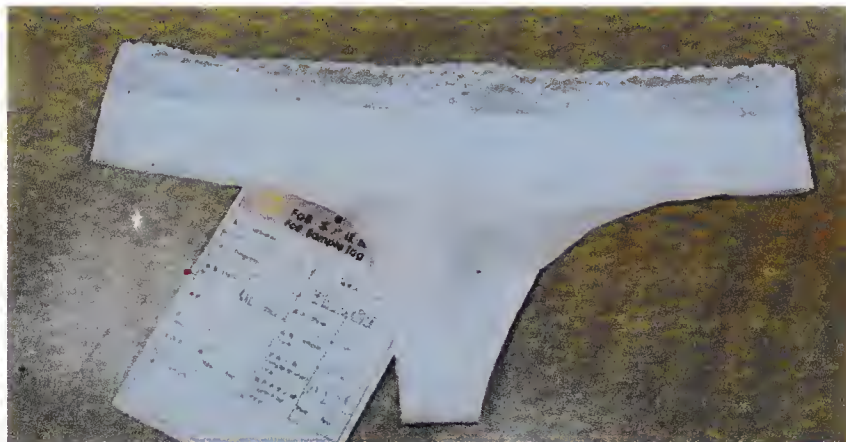
合隆技術標準指引

HopLun Technical standard direction

標準概述:	成品止口不外露
STANDARD BRIEF:	Seam allowance invisible for finished product
執行日期:	2013年10月22日
EXCUTION DATE:	22-Oct-13
跟進人員:	紙樣組長/紙樣技術員
FOLLOW-UP STAFFS:	Paper pattern/Technician

標準說明STANDARD EXPLANATION:

如圖里浪骨位紙格折回會有凸出尖角止口.類似款統一在出紙格時修掉尖角，確保成品后止口不外露。

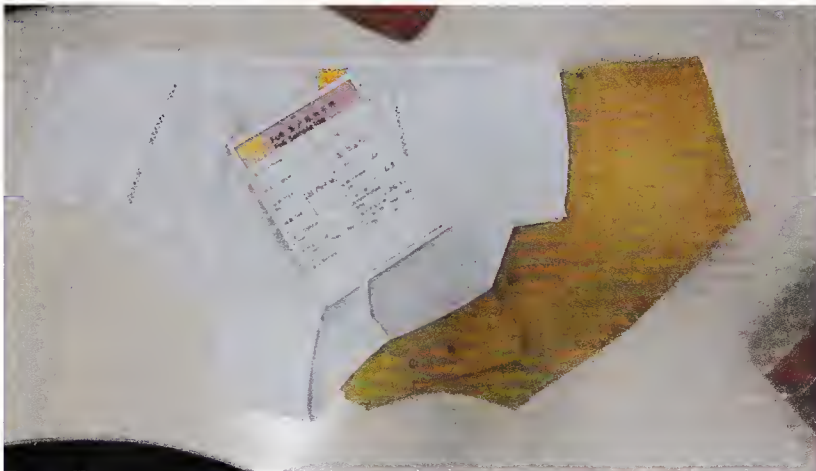


備注說明Remarks:



合隆技術標準指引

HopLun Technical standard direction

標準概述:	浪布与後浪骨位紙格出止口問題
STANDARD BRIEF:	Seam allowance of gusset fabric and back gusset
執行日期:	2015年6月1日
EXCUTION DATE:	1-Jun-15
跟進人員:	車間
FOLLOW-UP STAFFS:	Production line in sample room
標準說明STANDARD EXPLANATION:	
<p>討論浪布与後浪骨位紙格出子口問題.參考168-P-00094A款.已提供紙格給各工廠試車 , 工廠測試結果.建議統一將角補起來跟回原來紙格.</p>	
	
備注說明Remarks:	



合隆技術標準指引

HopLun Technical standard direction

標準概述:	浪位止口
STANDARD BRIEF:	The seam allowance of crotch
執行日期:	2014年8月16日
EXCUTION DATE:	16-Aug-14
跟進人員:	紙樣組長/技術技術員
FOLLOW-UP STAFFS:	Paper pattern leader/ Technician
標準說明STANDARD EXPLANATION:	
<p>浪位色丁布是橫紋無彈力的,前後幅浪骨位有彈力的,需將浪骨位的止口加大一邊加2MM,共4MM,後幅共加2MM,因為後浪是有弧度的,受紋路影響尺寸易小,如整件紋路相同的則不需要加大紙格(例如:MMA14E0220)</p> <p>Gusset is satin with woven - strap and inelastic. Front and back gusset seam are elastic. Seam allowance of gusset seam needs to increase 2MM each side, 4MM in all, back panel increases 2MM in all. Because back gusset is cambered, and it is easy to become small because of lines. It is not necessary to increase paper pattern if all lines are same. (For example,MMA14E0220)</p>	
	
備注說明Remarks:	



合隆技術標準指引

HopLun Technical standard direction

標準概述:	網樣增加基本碼的止口線
STANDARD BRIEF:	Add seam allowance line of a basic size for soft pattern
執行日期:	2013年11月19日
EXCUTION DATE:	19-Nov-13
跟進人員:	紙樣組長/紙樣技術員/辦房車間
FOLLOW-UP STAFFS:	Paper pattern/Technician/production line in sample room
標準說明STANDARD EXPLANATION:	
<p>工廠建議每款網樣增加1個基本碼的止口線.(提供止口線給工廠參考,因棉圍款,面杯布料不同,碗底及夾彎位甩的止口不同.)</p> <p>Add seam allowance line of a basic size for each soft pattern which suggested by factories.(porvide seam allowance line for factories's reference,different styles and different fabrics cause different seam allowance at the bottom cup and arm hole</p>	
備注說明Remarks:	



合隆技術標準指引

HopLun Technical standard direction

標準概述:	疊上碗款式的止口標準
Standard summarise :	Seam allowance standard of overlapping cup styles
執行日期:	2016年6月1日
Term of expiration date:	1-Jun-16
跟進人員:	紙樣組/辦房車間/工藝組
Follow-up staffs:	Pattern Team/Workshop in sample room/Technology tea
標準說明:	
Standard explanation :	

疊上碗的款式(見圖1),統一雞心及比位用6MM止口.(見圖2)
Unify 6MM seam allowance at gore and wing of overlapping cup styels

圖1. 款式圖
Style sketch



圖2.統一疊上碗的款雞心及比位用6MM止口.
Unify 6MM seam allowance at gore and wing of overlapping cup styels



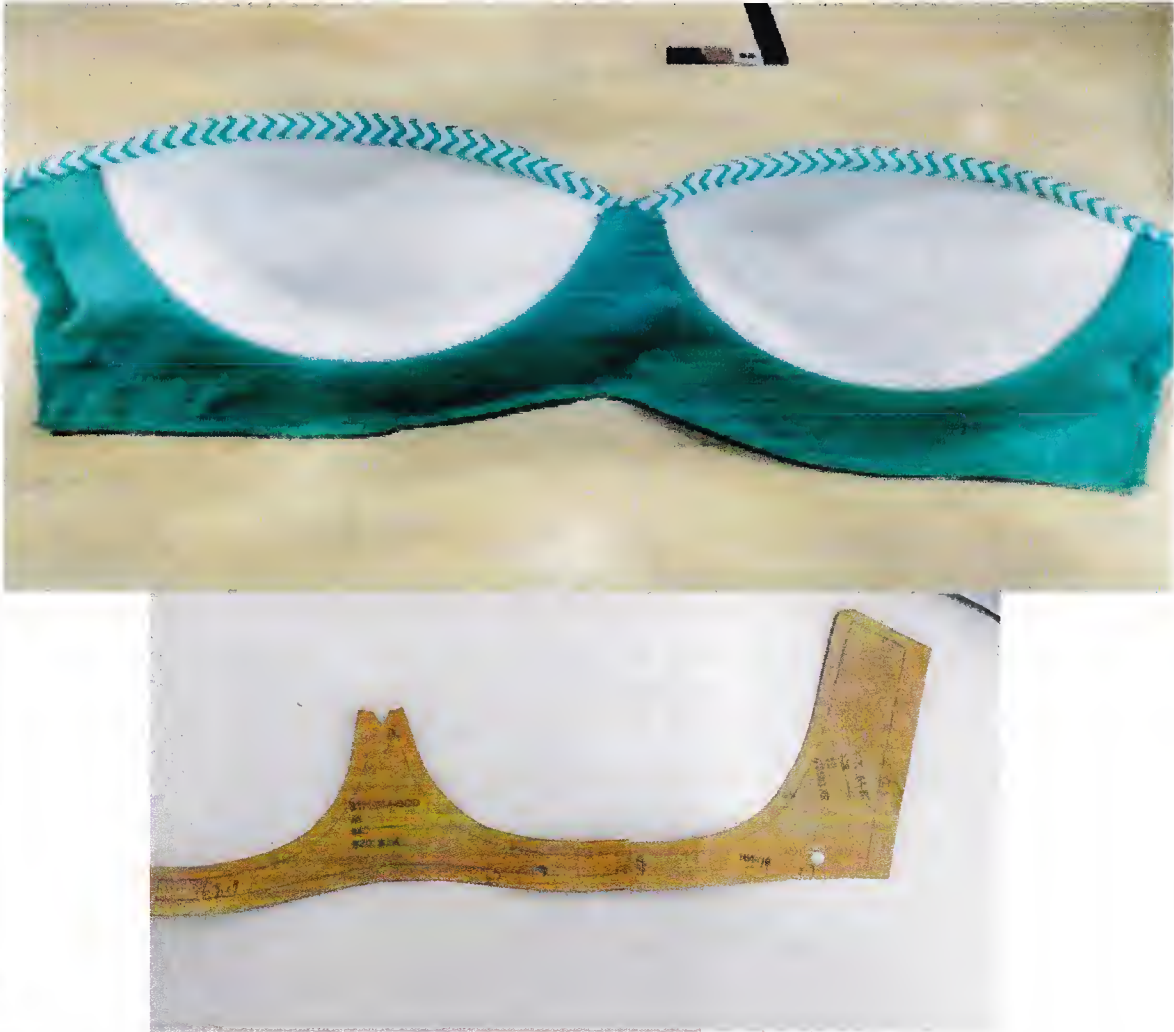
備注說明 Remarks:

標準概述:	統一包邊款紙樣止口標準
Standard summarise :	Seam allowance of wrapping style
執行日期:	2018年9月26日
Term of expiration date:	26-Sep-18
跟進人員:	跟單組/紙樣組/辦房車間
Follow-up staffs:	Merchandising/Pattern/Workshop
標準說明:	
Standard explanation :	<p>統一所有包邊款紙樣止口標準:Standard of seam allowance of wrapping style</p> <p>1:捆條出口封度1CM之內的(含1CM),全部出包滿止口. Wrap seam allowance complete if binding width within 1CM,incl.1CM</p> <p>2:捆條出口大於1CM的統一距針位外加2MM給止口.注意包布身止口根據針位大小決定.見圖示.Seam allowance is 2MM out from stitch if binding width more than 1CM. Notice that wrap fabric seam allowance depend on stitch size</p> <p>3:如有特殊款或客人要求除外.Except special style or guest requirement</p> <p>統一所有包邊款紙樣止口標準:</p> <p>1:捆條出口封度1CM之內的(含1CM),全部出包滿止口.Wrap seam allowance complete if binding width within 1CM,incl.1CM</p> <p>2:捆條出口大於1CM的統一距針位外露2MM給止口.注意包布身止口根據針位大小決定.見圖示.Seam allowance is 2MM out from stitch if binding width more than 1CM. Notice that wrap fabric seam allowance depend on stitch size</p> <p>3:如有特殊款或客人要求除外.Except special style or</p> <p>—— 代表捆條 standard for</p> <p>—— 代表布身止口 standard for fabric seam</p> <p>----- 代表坎車針位 standard for stitch</p> <p>針位stitch</p> <p>距針位加2MM止口. seam allowance is 2MM out from</p>
備注說明 Remarks:	



合隆技術標準指引

HopLun Technical standard direction

標準概述:	統一紙樣畫車縫止口線
Standard summarise :	Stitch of sewing seam allowance
執行日期:	2017年8月2日
Term of expiration date:	2-Aug-17
跟進人員:	紙樣組/辦房車間/大货技术员
Follow-up staffs:	Pattern/Workshop/Technician
標準說明:	
Standard explanation :	
統一所有款式紙樣按車縫線位置出止口.(例如上碗止口是6MM就畫6MM止口線)具體車法請看款式圖做.	
Pattern make seam allowance according sewing positon, for example, seam allowance of join cups together with wings and gore is 6MM, pattern should draw 6MM. Specific sewing depend on style	
	
備注說明	Remarks:

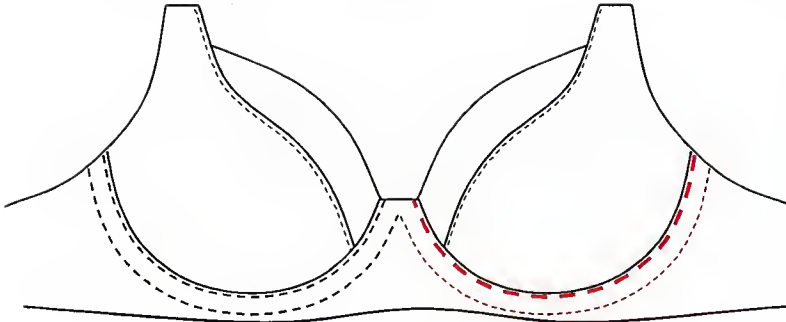
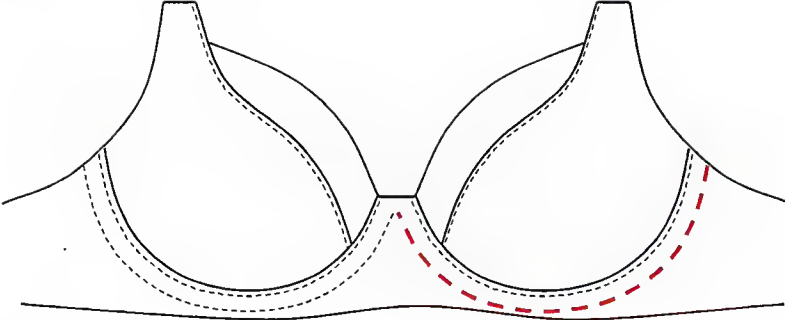
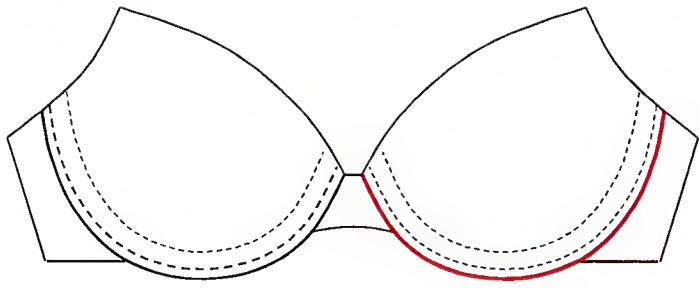


合隆技術標準指引

HopLun Technical standard direction

2、紙樣標準類 Pattern Standard

2-5、紙樣特殊標準 Pattern Special Standard

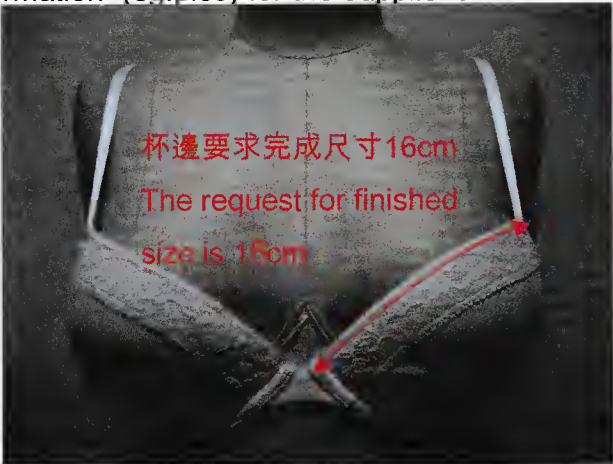
標準概述:	如何在尺寸表上注明網碗長
STANDARD BRIEF:	How To Mark Wire Casing Length In Size Chart
執行日期:	2011年6月20日
EXCUTION DATE:	20-Jun-11
跟進人員:	紙樣組長/技術員
FOLLOW-UP STAFFS:	Pattern Team Leader / Technician
標準說明STANDARD EXPLANATION: 根據款式選擇以下三種備注描述標準。 According to the style, choose the following three remarks to describe their standard .	
<div style="display: flex; align-items: center;">  <div style="margin-left: 20px;"> <p>1. 順網碗: 沿雙針線內線度 This seam allowance outwards after sewing wire casing on cup btm: measure along inner line.</p> </div> </div>	
<div style="display: flex; align-items: center;">  <div style="margin-left: 20px;"> <p>2. 順網碗: 沿雙針線外線度 This seam allowance outwards after sewing wire casing on cup btm: measure along outer line</p> </div> </div>	
<div style="display: flex; align-items: center;">  <div style="margin-left: 20px;"> <p>3. 倒網碗: 沿邊度 This seam allowance inwards after sewing wire casing on cup btm: measure along edge</p> </div> </div>	
備注說明Remarks: 客人有特別要求的除外。 Except for the especial requirement from customers .	

標準概述:	模杯杯邊尺寸的特別要求
STANDARD BRIEF:	The Especial Rqst Of Mould Cup Edge Size
執行日期:	2011年4月6日
EXCUTION DATE:	6-Apr-11
跟進人員:	紙樣組長/模杯組
FOLLOW-UP STAFFS:	Pattern Team Leader / Mould Team

標準說明STANDARD EXPLANATION:

當客人要求模杯款完成的杯邊尺寸不可長時, 做淨身模杯時需比成品模杯短0.2cm, 紙樣師傅需在模杯資料上注明'杯邊尺寸不可偏長'字樣(如圖3), 便於模杯供應商特別留意.

If client requests the cup edge should not extend, make mould cup 0.2cm shorter than finished,and pattern team need to mark " cup edge should not extend" on <Mould-cup Information>(eg.pic3) for the supplier to notice easily.



Pic1.



Pic2.

K	Front neckline of Padding 棉墊上杯邊								
L	Cup height of Padding 棉墊杯高								
M	Bottom length of Padd 棉墊碗邊								

在<<合迅技術發展中心模杯資料表>>的備注檔注明特別要求.

Mark the especial request on <He Xun Technical Development Centre Mold-cup Information>.

Remark 備注: Please note. 請留意部位A/B/C/E處尺寸計不對應。

杯邊尺寸不可偏長
the cup edge should not be made longer.

Created by 制表: Re-checked by 審核:

Pic3.

備注說明Remarks:



合隆技術標準指引

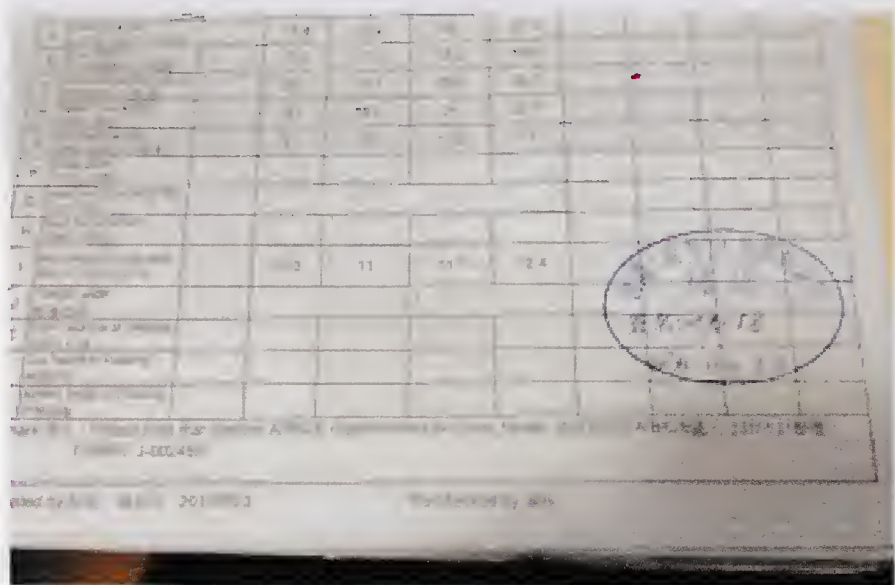
HopLun Technical standard direction

標準概述:	模杯資料描述
STANDARD BRIEF:	Description of mould cup
執行日期:	2014年3月20日
EXCUTION DATE:	20-Mar-14
跟進人員:	紙樣
FOLLOW-UP STAFFS:	Paper pattern

標準說明STANDARD EXPLANATION:

統一模杯資料上只可以顯示一種中英文描述一致的備注,不可以同時顯示計/不計壓邊的中英文描述備注.

Uniformly, mould cup data can only show a kind of remark, and description in English and Chinese must be consistent. It is not allowed to show different descriptions in English and



備注說明Remarks:

標準概述:	紙樣尺寸應與尺寸表中尺寸一樣
STANDARD BRIEF:	Size in paper pattern should be the same with size chart
執行日期:	2014年8月16日
EXCUTION DATE:	16-Aug-14
跟進人員:	紙樣組長/技術技術員
FOLLOW-UP STAFFS:	Paper pattern leader/ Technician
<p>標準說明STANDARD EXPLANATION:</p> <p>近車間經常反應前/後中長紙樣達不到尺寸,一般都要少0.3-0.4CM,如果前/後尺寸是折度,從理論上說紙樣是OK的,但是車間反應建意紙樣應出與尺寸表一樣的尺寸,以免車間成品貨短,如087-M-00018</p> <p>Recently, workshop often reflect center front/ back panel on paper pattern can not reach size, generally, it always 少0.3-0.4CM. If front /back size is 折度的, in theory, paper pattern is OK. However, workshop suggests that the size on paper pattern should be consistent with size spec lest the size of finished product is short. For example, 087-M-00018.</p> 	
備注說明Remarks:	



合隆技術標準指引

HopLun Technical standard direction

標準概述:	款式及紙樣特殊做法
STANDARD BRIEF:	The method of special styles and paper pattern
執行日期:	2014年11月25日
EXCUTION DATE:	25-Nov-14
跟進人員:	紙樣組長/紙樣技術員
FOLLOW-UP STAFFS:	Paper pattern/Technician
標準說明STANDARD EXPLANATION:	
<p>款式及紙樣特殊做法,對車縫有難度的,在做頭板時就需提出來並寫在跟蹤表上(038-N-00247),新單浪布改做法.</p> <p>It is difficult for special style and paper pattern to sew. Hence, it is necessary to bring it up and write in a tracking table while 做頭板 (038-N-00247). 新單 gusset fabric 改做法.</p> 	
備注說明Remarks:	

標準概述:	特殊花邊紙樣做法
Standard summarise :	Pattern of special lace
執行日期:	2017年8月16日
Term of expiration date:	16-Aug-17
跟進人員:	紙樣組/用量組/辦房車間/大货技术员
Follow-up staffs:	Pattern/Unit consumption/Workshop/Technician

標準說明:
Standard explanation :

波型有不同,是可以循環的,花波很高,波位很寬的花邊.款式要求紙樣要固高波(註:可以固定任何一個波的).統一紙樣要出花波型,并提供一套每個碼可以選擇不同波位的排麥圖(在圖上畫好紙樣線的,見下圖)按大貨流程給工廠.板房也要留底一份跟資料走.(此做法可以節約用量)(案例087-S-00516)

Lace with high and wide scallop and different shape can be circular, pattern should fix any high scallop and make scallop shape and offer a set of marker with different scallop on each size to factory, keep a copy in sample room (The method can save consumption)



備注說明 Remarks:



合隆技術標準指引

HopLun Technical standard direction

標準概述:	特殊款要求加燙工序
Standard summarise :	Iron process for special styles
執行日期:	2017年3月15日
Term of expiration date:	15-Mar-17
跟進人員:	紙樣組/辦房車間/工藝組
Follow-up staffs:	Pattern Team/Workshop in sample room/Technology tea

標準說明:
Standard explanation :

要求加燙工序的特殊款式(見圖1),統一板由紙樣師傅在備註欄備註需加燙.
For special style need iron, unify that pattern maker remark in the remarks column

圖1. 款式圖
Styel sketch



備注說明 Remarks:



3、厄位標準類

Notch Standard

3-1、紙樣厄位標準

Pattern notch standard

標準概述:	浪位的紙樣做法
STANDARD BRIEF:	Methods Of Making Paper Pattern Of Gusset
執行日期:	2011年11月3日
EXCUTION DATE:	3-Nov-11
跟進人員:	紙樣組長/辦房車間
FOLLOW-UP STAFFS:	Pattern Team Leader / Sample Workshop

標準說明STANDARD EXPLANATION:

里浪對面浪,浪比兩邊沒有對齊,有間距尺寸的款式,為保證左右對稱,統一在前后幅加凸刀口對里浪

Comparing crotch lining to shell,if both gusset edges are not aligned and have spacing,to assure r/l spacing symmetric,standardly add protruding notch on b/f rise to follow crotch lining:

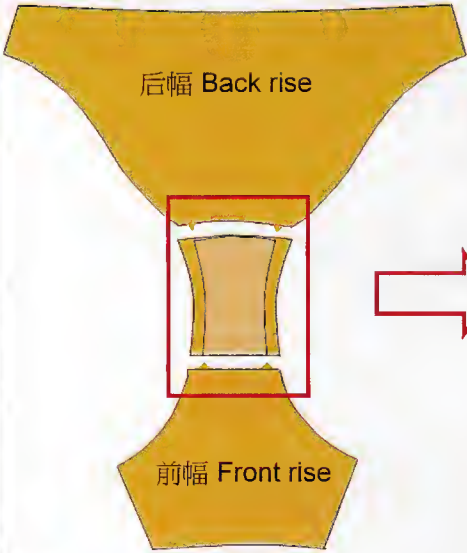
1.里浪對面浪有間距的款式 Style with crotch lining and shell having spacing:




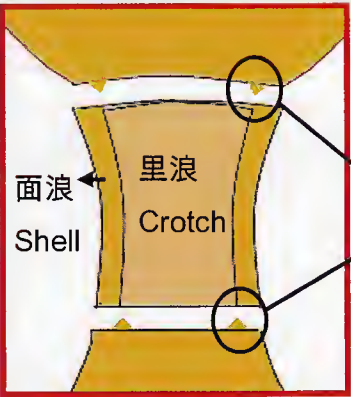




2.該款式紙樣圖 Paper patterns of the aboving style:







前后幅加凸刀口對里浪,以便對位.

Add protruding notch to follow crotch lining for

備注說明Remarks:

標準概述:	紙格V位統一不打刀口
STANDARD BRIEF:	Don't Make Notch At Any "V" On Paper Pattern.
執行日期:	2011年6月20日
EXCUTION DATE:	20-Jun-11
跟進人員:	紙樣組長/車間總指導
FOLLOW-UP STAFFS:	Pattern Team Leader / Sewing Team Leader

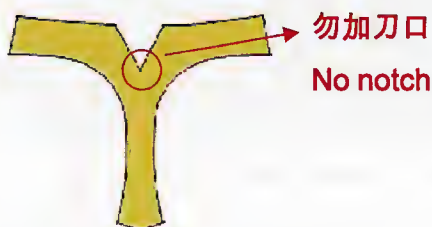
標準說明STANDARD EXPLANATION:

有V位的款式, 不管褲款或圍款, 紙格V位統一不打刀口, 車縫完成后請手工打刀口。
Whether briefs or bras, if with V pattern, don't make notch on paper pattern, but pls make notch manually after sewing.

1. 有V位的褲款后幅圖. Example: back rise with "V" pattern.



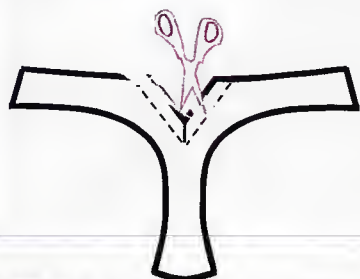
2. 該款后幅紙樣正確做法 Correct paper pattern is as follow:



注意Notice:

請在單針夾后中V字這道工序時連帶在對正尖位打刀口(如圖所示).

Pls make notch at the triangle plm after s/n l/s join V shape seam at c/b (Shown by pict.)



車縫連帶打刀口一個
Incl. making one notch after s/n
l/s join V shape seam at c/b

備注說明Remarks:



合隆技術標準指引

HopLun Technical standard direction

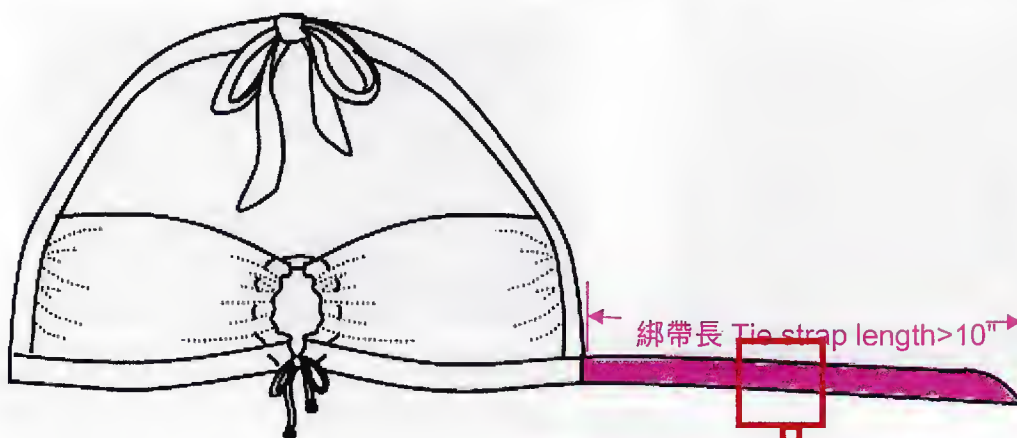
標準概述:	綁帶超過10"的刀口對位
STANDARD BRIEF:	How to deal with paper pattern of tie strap longer than 10"
執行日期:	2011年11月3日
EXCUTION DATE:	3-Nov-11
跟進人員:	紙樣組長/車間總指導
FOLLOW-UP STAFFS:	Pattern Taem Leader / Sewing Team Leader

標準說明STANDARD EXPLANATION:

綁帶超過10"的款式,為防止其綁帶在車縫時扭紋,需在紙樣上增加刀口便于對位.

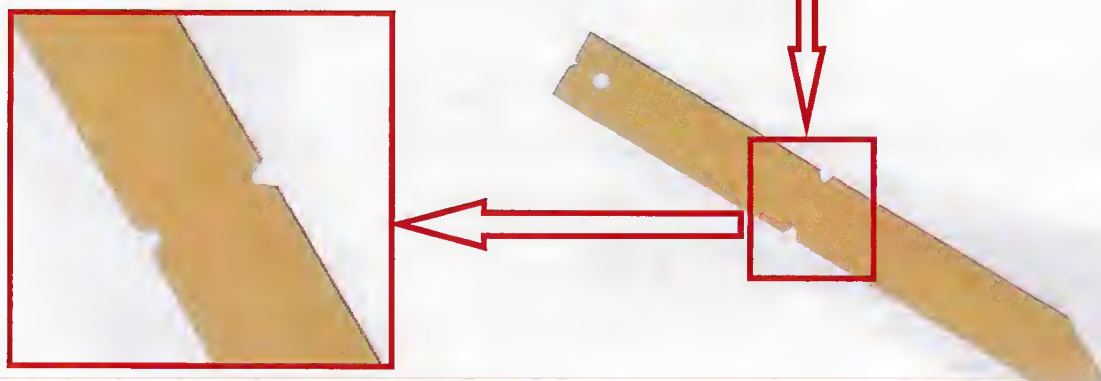
For tie straps longer than 10",in order to prevent twist line on sewing ,pls add notch on paper pattern to match.

1.綁帶超過10"的款式圖Style with tie straps longer than 10":



2.綁帶紙樣需增加刀口便于對位.

Notch is needed against twist line on paper pattern of tie straps:



備注說明Remarks:

標準概述:	圍款後比里布要加刀口位
Standard summarise :	Add Notch For The Bra Style That Lining Fabric At B.K Wing
執行日期:	2012年4月19日
Term of expiration date:	19-Apr-12
跟進人員:	紙樣組長/辦房車間/工藝組
Follow-up staffs:	Pattern Team/Workshop/Technical Team

標準說明STANDARD EXPLANATION:

圍款後比有里布,面層下比位是喱士花波的款式(如下圖所示),后下比放肩帶位在里層布上一定要加刀口對位, 加凸刀口還是凹刀口須按布料而定。

For the bra style that lining fabric at bk wing and fabric is lace at shell btm wing(as below pic.),pls be sure to add notch at lining fabric of bk btm wing where shoulder strap is here and to follow notch,the type of notch depends on fabric type.



比位裡布需在耳仔位增加厄位。
Add notch at lining of fabric pattern.

備注說明Remarks:

合隆技術標準指引

HopLun Technical standard direction

標準概述:	有下扒的款式鸡心上碗位需要打厄位的要求
STANDARD BRIEF:	Rqst Of C.F. Paper Pattern For The Style With Cradle
執行日期:	2011年1月21日
EXCUTION DATE:	21-Jan-11
跟進人員:	紙樣組長
FOLLOW-UP STAFFS:	Pattern Tean Leader

標準說明STANDARD EXPLANATION:

面杯雞心位需左右對稱的款式,其雞心位紙樣對杯骨位處需加刀口, 如下圖:

The C.F paper pattern must add notches if the bra has T seam and cradle. Shown by the picture below:

1. 款式圖(Picture of style):



2. 雞心位紙樣刀口制作標準(The standard of how to make the notch at the CF paper pattern):



備注說明Remarks:

標準概述:	一字圍款內袋開口在側骨位的厄位
STANDARD BRIEF:	The notch for the strapless styles whose inside pocket located at the side seam.
執行日期:	2013年4月24日
EXCUTION DATE:	24-Apr-13
跟進人員:	紙樣組長/辦房車間
FOLLOW-UP STAFFS:	Paper pattern leader and product line in sample room
<p>標準說明STANDARD EXPLANATION:</p> <p>一字圍款內袋開口在側骨位的，面層需縮褶的款式統一在側骨面布紙格上增加凸刀口對內袋開口位,面層沒有縮褶的款打凹刀口,以確保大內袋左右對稱,</p> <p>For the bandeau,when inside pocket located at the side seam and needed to shrinkage on the shell fabric.Unify to add bulge notch on side seam shell fabric pattern to match the open on the inside pocket. And if there is no shrinkage on the shell fabric, unify to add to heart-shaped to ensure symmetrical on left and right side.</p>	
	
備注說明Remarks:	



合隆技術標準指引

HopLun Technical standard direction

標準概述:	內袋碗底刀口
STANDARD BRIEF:	The notch of inside pocket bottom cup
執行日期:	2014年3月20日
EXCUTION DATE:	20-Mar-14
跟進人員:	紙樣
FOLLOW-UP STAFFS:	Paper pattern
標準說明STANDARD EXPLANATION:	
<p>因杯底位打凹刀口走線後看不見刀口,無法對捫位及骨位,內袋碗底刀口统一碗骨为凹刀口、碗底为凸刀口</p> <p>The notch will be invisible when sewing if make heart-shaped notch on bottom cup ,can not match the notch and the seam. So, we unify the notch of inside pocket bottom cup to heart-shaped notch and the bottom cup to bulge notch.</p>	
	
備注說明Remarks:	

合隆技術標準指引

HopLun Technical standard direction

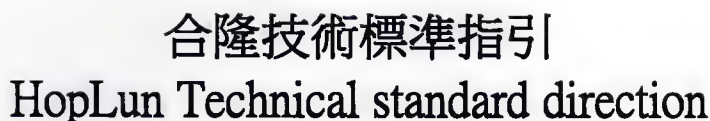
標準概述:	統一取消刀口,增加麥頭完成尺寸.
STANDARD BRIEF:	Unify to cancel the notch and add the finished size of label
執行日期:	2015年4月28日
EXCUTION DATE:	28-Apr-15
跟進人員:	紙樣組長/車間
FOLLOW-UP STAFFS:	Paper pattern/ Sewing room
<p>標準說明STANDARD EXPLANATION:</p> <p>比位是喱士款,比彎位紙格有出凸刀口對定麥頭,現工廠建議取消刀口,增加參考尺寸定麥頭.(參考445-P-00021C款)</p> <p>When the wing is lace, there is bulge notch to match fixing the label of wing pattern.Now factories suggest cangle the notch and add reference size to fix the label(445-P-00021C for reference)</p> 	
<p>備注說明Remarks:</p> <p>統一取消刀口,增加麥頭完成尺寸.</p> <p>Unify to cancel the notch, add the finished size of label</p>	



合隆技術標準指引

HopLun Technical standard direction

標準概述:	喱士,花邊,網布布料打凸刀口
STANDARD BRIEF:	Bulge notch on fabric like lace/mesh
執行日期:	2014年8月16日
EXCUTION DATE:	16-Aug-14
跟進人員:	紙樣組長/技術技術員
FOLLOW-UP STAFFS:	Paper pattern leader/ Technician
標準說明STANDARD EXPLANATION:	
<p>1.如339-M-00351款前中破骨,腰頭車丈根的,腰頭位置不用加刀口.</p> <p>It needn't to add the notch at the waist for the style with cut seam at front rise and sewing elastic at the waist, Such as 339-M-00351</p> <p>2,如.458-M-00044前中破骨腰頭拉丈根的,刀口應加在前中骨位.</p> <p>The notch should be at the seam of front rise for the style with cut seam at front rise and attach elastic at the waist. Such as 458-M-00044</p> <p>3,如:C8F3PT009側幅花邊區分方向的刀口應加在側骨位置,褲頭及褲比不好區分的加在側骨靠腰頭位置.(此點不限於花邊,其它布料難區分褲頭褲比位置的也適用)</p> <p>The notch should be at the seam if lace need to distinguish the direction at side panel. And the notch should be at the side seam nearby waist if lace can not distinguish the direction easily at waist and legopening</p> <p>以上三點用於常見款,喱士,花邊,網布布料需打凸刀口的.作用在於盡量避免刀口在褲頭及褲比丈根較小成品外露只口</p> <p>Above three items are common.It need to add bulge notch on fabric like lace/mesh which can avoid small notch at waist and legopening and seam allowance visible.</p>	
備注說明Remarks:	

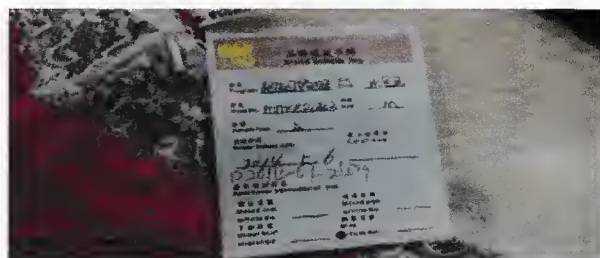
3-1-10

標準概述:	增加V位凸刀口
STANDARD BRIEF:	Add bulge notch of V shape
執行日期:	2015年3月26日
EXCUTION DATE:	26-Mar-15
跟進人員:	紙樣組長/車間
FOLLOW-UP STAFFS:	Paper pattern/ Sewing room

標準說明STANDARD EXPLANATION:

如前下幅裁片中間V型不是很V的款.因大貨裁片看不清V位.建議以後類似款增加V位凸刀口方便大貨生產.(參考款:超值時尚組.MMS15B0303款)

For some V shape is not V enough, can not be clearly on bulk cut pieces, please add bulge notch at V location to make bulk production easily (MMS15B0303 for reference)



備注說明Remarks:

待与工廠溝通後再討論.

Discuss after communicating with factories.

標準概述:	增加凹刀口
STANDARD BRIEF:	Add concave notch
執行日期:	2015年3月26日
EXCUTION DATE:	26-Mar-15
跟進人員:	紙樣組長/車間
FOLLOW-UP STAFFS:	Paper pattern/ Sewing room
<p>標準說明STANDARD EXPLANATION:</p> <p>下脾是拉襟丈根車滿子口,而且脾与丈巾是撞色的,成品還要下脾放肩帶的刀口.工廠建議下脾後肩帶改為凹刀口,不用再修剪. (參考款:070-L-00078款)</p> <p>For the styles of lower wing attach&topstitch seam allowance and colour contrast with elastic, and strap to the lower wing when finished. Factories suggest that concave notch on back strap at lower wing without trimming</p> <div data-bbox="275 1112 955 1630" data-label="Image">  </div>	
<p>備注說明Remarks:</p> <p>下脾是拉襟丈根車滿子口需要放肩帶的,統一打內刀口.如遇網孔大的布料加後帶距參考尺寸.具體網孔多大加後帶距尺寸在做板時提出而定.</p>	



合隆技術標準指引

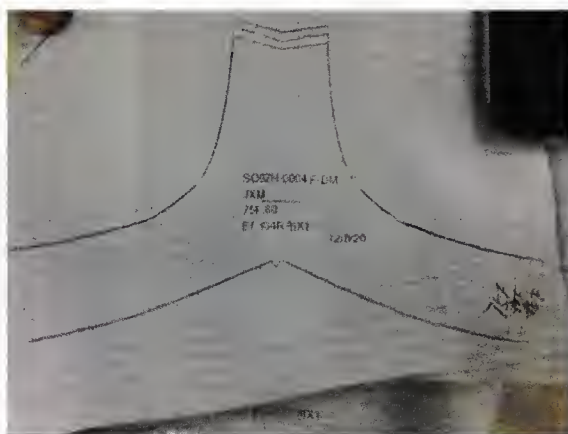
HopLun Technical standard direction

標準概述:	雞心連下扒的刀口
STANDARD BRIEF:	The notch of gore through cradle
執行日期:	2014年3月20日
EXCUTION DATE:	20-Mar-14
跟進人員:	紙樣
FOLLOW-UP STAFFS:	Paper pattern

標準說明STANDARD EXPLANATION:

雞心連下扒的款式,雞心位是成V的,建議所有布料V位打凸刀口

For the styles of gore through cradle , make bulge notch with V shaped at CF for all fabric with V shpe



備注說明Remarks:

標準概述:	泳衣剪口
STANDARD BRIEF:	Notch of swimwear
執行日期:	2014年3月20日
EXCUTION DATE:	20-Mar-14
跟進人員:	紙樣/辦房車間
FOLLOW-UP STAFFS:	Paper pattern/Production line in sample room

標準說明STANDARD EXPLANATION:

- 1:頸帶及比尾帶骨位較寬(4CM以上),骨位到刀口位的距離太近,造成单针包骨位內的布无法伸展,現統一骨位距剪口不可以小於3CM,如圖示1
- 2:杯位有棉,側比帶開口位太小,造成单针包骨位內的布无法伸展及棉成品會有折痕,現統一將剪口開口位長度改為4-4.5CM,如圖示2;(客人有特殊要求除外)
- 1: Neck strap is wider than the end(More than 4CM), the distance between the seam and 刀口位 is too closed, which causes fabric of 单针包骨位內 can not be stretched. At present, unify the distance between seam and notch can not less than 3CM, for example, picture 1.
- 2: Cup is padded, and opening of 側比帶 is too small, which causes fabric of 单针包骨位




備注說明Remarks:



合隆技術標準指引

HopLun Technical standard direction

標準概述:	大雞心雞心腳中間加剪口
Standard summarise :	Increase notch at gore bottom
執行日期:	2017年12月14日
Term of expiration date:	14-Dec-17
跟進人員:	紙樣組/辦房車間/大货技术员
Follow-up staffs:	Pattern/Workshop/Technician
標準說明:	
Standard explanation :	<p>雞心是三層或二層的,統一此种長下扒大雞心,在雞心腳中間加剪口.</p> <p>Unify that increase notch at big gore with cradle with 2 or 3 layer</p>
	
備注說明 Remarks:	

標準概述:	麥頭對剪口標準
Standard summarise :	Standard of matching label with notch
執行日期:	2017年2月22日
Term of expiration date:	2017年2月22日
跟進人員:	紙樣組/辦房車間/工藝組
Follow-up staffs:	Pattern Team/Workshop in sample room/Technology tea

標準說明:
Standard explanation :

(見圖1)紙樣麥頭對剪口標準,統一以下:

一:麥頭完成居中位置的,麥頭中間對剪口中間.(例如後腰中間)

二:麥頭完成距夾或距側骨的,麥頭邊對剪口,紙樣師傅要給麥頭距夾或距側骨的參考尺寸.

Unify the standard of matching label with noth as following:

1. Label at ceter as finished, the middle of the label match with the middle of notch
2. Label near armhole or side seam, label edge match the notch. Pattern maker should offer the size.

圖1. 款式圖

Style sketch

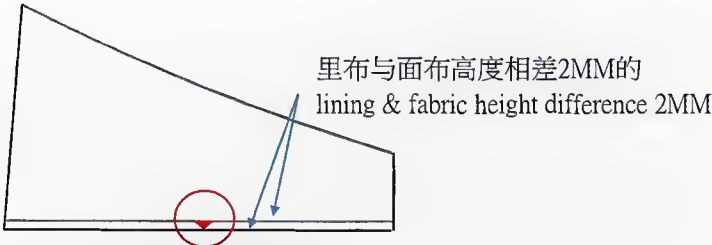


備注說明 Remarks:



合隆技術標準指引

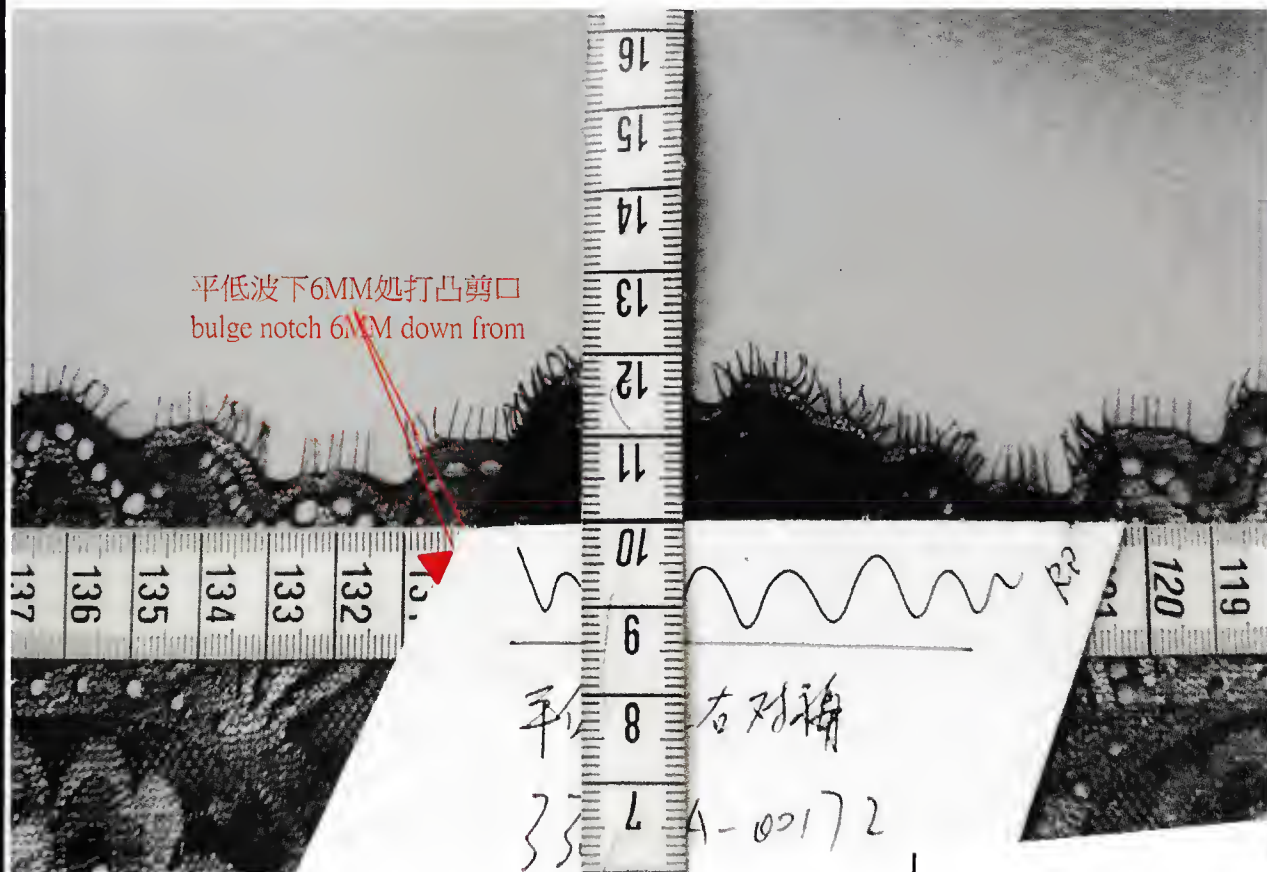
HopLun Technical standard direction

標準概述:	后比加刀口区分里面层
Standard summarise :	Increase notch at back wing to distinguish lining & fabric
執行日期:	2018年5月9日
Term of expiration date:	9-May-18
跟進人員:	纸样组/辦房車間/大货技术员
Follow-up staffs:	Pattern/Workshop/Technician
標準說明:	
Standard explanation :	
統一后比里布与面布是同种料,高度相差2MM的,在里布增加刀口区分底面.	
Lining & fabric of back wing are the same fabric, and height difference 2MM, increase notch at lining to distinguish lining & fabric	
<div><p>里布与面布高度相差2MM的 lining & fabric height difference 2MM</p><p>里布加刀口区分里面层 increase notch at lining to distinguish lining & fabric</p></div>	
備注說明 Remarks:	

標準概述:	花波加刀口
Standard summarise :	Increase notch at scallop
執行日期:	2018年7月4日
Term of expiration date:	4-Jul-18
跟進人員:	跟單組/紙樣組/辦房車間/大貨技術員
Follow-up staffs:	Merchandising/Pattern/Workshop/Technician
標準說明:	
Standard explanation :	

如下圖,花邊波位太高,有里布的,布边要平低波的款式.統一要在花波位高的那邊增加凸刀口,(刀口位置,平低波往下6MM加凸剪口)

Lace scallop is too high and fabric edge alligns valley with lining, unify that increase a bulge notch at high scallop, 6mm down from valley



備注說明 Remarks:

花邊波位高度1CM以上統一加凸剪口,如有低于1CM以下的需要加剪口,就看實際款式決定.
Increase bulge notch when lace scallop's height more than 1CM. Depend on style decide to increase notch when lace scallop's height less than 1CM



合隆技術標準指引

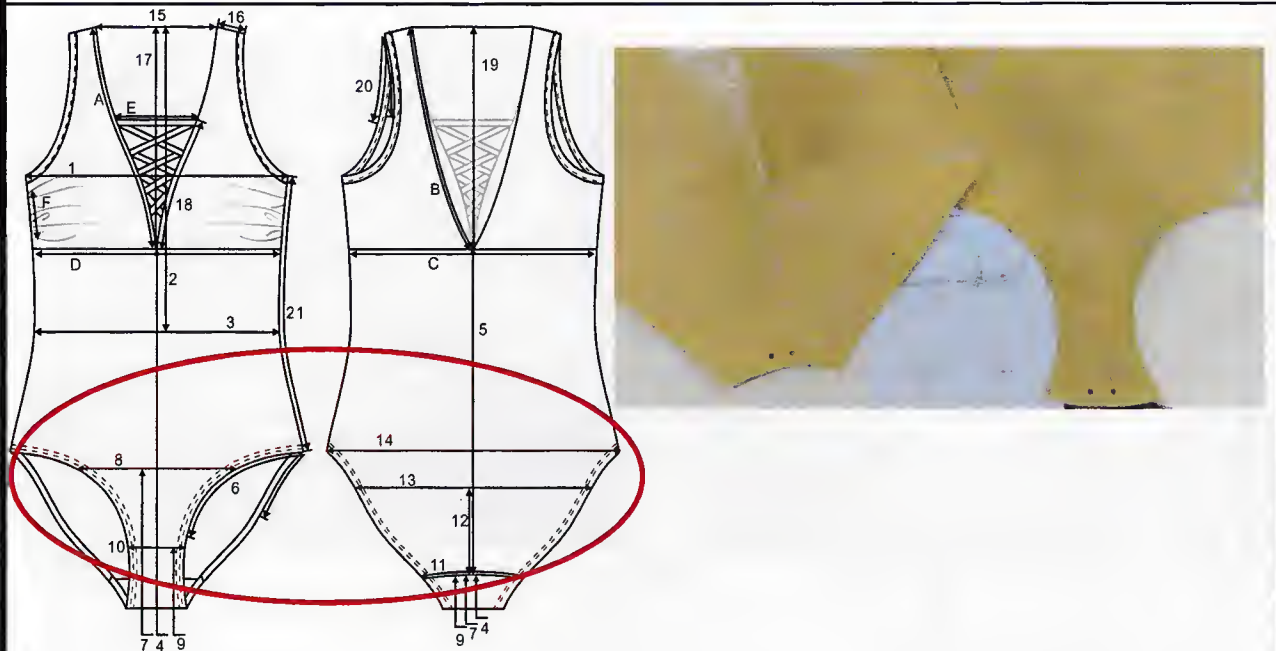
HopLun Technical standard direction

標準概述:	前後幅闊加剪口要求
Standard summarise :	Requirement of increasing notch at front & back panel
執行日期:	2017年12月14日
Term of expiration date:	14-Dec-17
跟進人員:	紙樣組/辦房車間/大货技术员
Follow-up staffs:	Pattern/Workshop/Technician

標準說明:
Standard explanation :


統一凡是有前後幅闊有尺寸的在尺寸位置底面層都加剪口.(註:如果遇后幅要縮折的款式,就以縮折剪口為準)

Increase notch at bottom and shell for front & back panel with measurement. Take shirring notch as correct if back panel with shirring.



備注說明 Remarks:

HopLun Technical standard direction

標準概述:	统一软纱要打凸刀口.
Standard summarise :	Mark bulge notch at soft mesh
執行日期:	2017年8月16日
Term of expiration date:	16-Aug-17
跟進人員:	紙樣組/辦房車間/大货技术员
Follow-up staffs:	Pattern/Workshop/Technician
標準說明:	
Standard explanation :	
<p>统一软纱要打凸刀口.</p> <p>All soft mesh should mark bulge notch</p>	
	
備注說明 Remarks:	



合隆技術標準指引

HopLun Technical standard direction

標準概述:	紙樣在雞心腳中間加一個凹刀口
Standard summarise :	Increase a concave notch at middle of gore bottom in pattern
執行日期:	2016年1月1日
Term of expiration date:	1-Jan-16
跟進人員:	紙樣組/辦房車間/工藝組
Follow-up staffs:	Pattern Team/Workshop in sample room/Technology tea

標準說明: Standard explanation :

(見圖1)鸡心脚中间拉丈根完成交叉款,統一紙樣在雞心腳中間底面層加凹刀口.(除大孔網布/喱士布/雪紡布不打刀口,但定型紗所有款都要要打凹刀口)(見圖2)

Crossed after attaching elastic at middle of gore bottom(sketch1), unify that increase a concave notch at middle layer in pattern. Except for big hole mesh, lace, chiffon.(sketch 2)

圖1. 款式圖

Style sketch

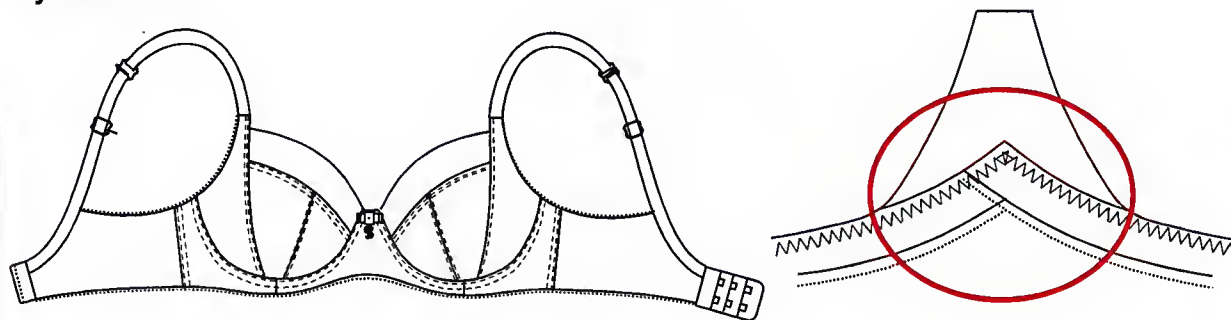
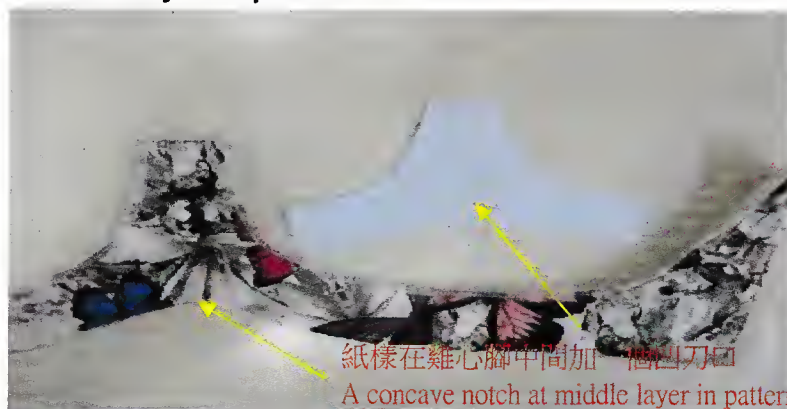


圖2.紙樣在雞心腳中間加一個凹刀口

A concave notch at middle layer in pattern



備注說明 Remarks:



合隆技術標準指引

HopLun Technical standard direction

3、厄位標準類

Notch Standard

3-2、棉杯厄位標準

Foam cup notch standard

標準概述:	模杯里层是粘棉拉布或平紋布的款式的厄位工艺编写要求
STANDARD BRIEF:	Technics Rqst Editing Of Notch For Mould-cup That Use The Cotton Or Jersey Fabric To Laminate
執行日期:	2011年4月6日
EXCUTION DATE:	6-Apr-11
跟進人員:	工藝員
FOLLOW-UP STAFFS:	Craft

標準說明STANDARD EXPLANATION :

模杯款式,杯里是粘棉拉布或平紋布的款式,因模杯厄位不明顯,所以在編寫工藝書時需在上碗工序前增加一道工序: 人工點模杯厄位.

For mould-cup style that uses the cotton or jersey fabric to laminate, we need to add another procedure when editing craft book: make a notch on mould cup by hand .

1.為裡杯粘平紋布的模杯,厄位不清晰(如圖1):

The following is mould cup with jersey fabric lining,of which the notch is not clear(as Pic1):

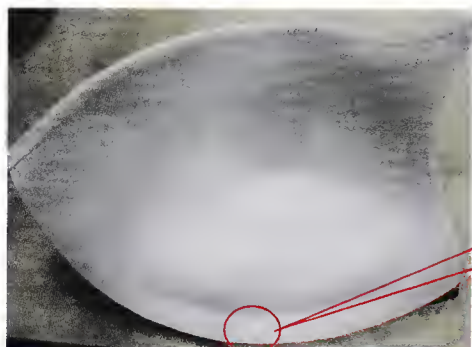


圖1

模杯上的厄位不清晰.

The notch on mould cup is not clear.

2. 增加手工點位后(如圖2).

. after being added a notch by hand(as Pic 2).

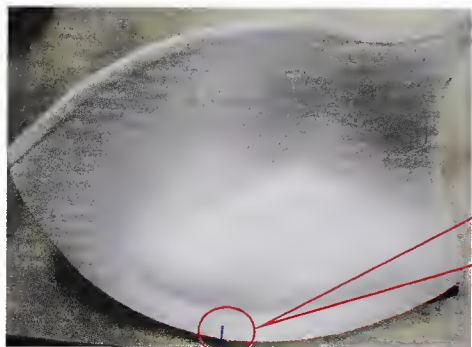


圖2.

編寫工藝書時, 需增加:

人工點模杯厄位工序.

Add a procedure in operation

chart:make a notch on mould by

備注說明Remarks:

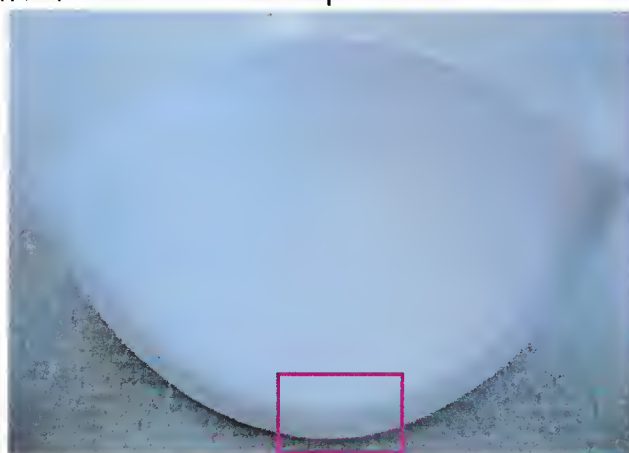
標準概述:	模杯厄位標準
STANDARD BRIEF:	Standard Of Mold-cup Notch
執行日期:	2011年8月16日
EXCUTION DATE:	16-Aug-11
跟進人員:	模杯辦組/車間總指
FOLLOW-UP STAFFS:	Mould Sample Team/Workshop Line Leader

標準說明STANDARD EXPLANATION:

從即日起,模棉綑碗位的厄位長度為0.7cm,寬度為0.1cm.

From now on,the length of notch on wire casing of mold-cup is 0.7cm,and width is 0.1cm.

1.模杯厄位Notch on mould cup:



模杯上的厄位尺寸標準:

standard of Notch on mould cup.

寬度width: 0.1cm.

長度length: 0.7cm



備注說明Remarks:

8月10號模杯辦房已發郵件確定并要求供應商執行.

Mould sample room had confirmed by emails on 10, Aug. And required the supplier to carry out.

標準概述:	模面杯有半月花边的款式厄位要求
Standard summarise :	Whether need to add notchs at shell cup pattern
執行日期:	2012年4月19日
Term of expiration date:	14-Jun-12
跟進人員:	紙樣組長(模杯)/辦房車間
Follow-up staffs:	Pattern team leader / Sewing floor in sample room

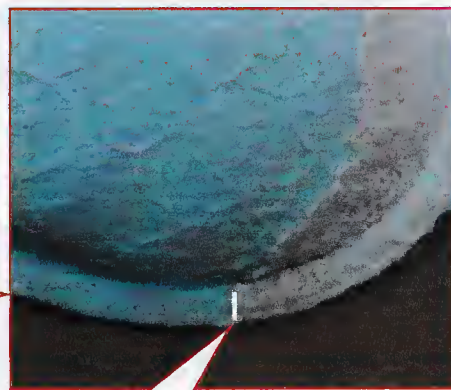
標準說明:

Standard explanation :

- 1.棉杯与面杯是模杯,且面杯有半月花边的款式(如下圖)統一在棉边碗底增加对花边的扼位.
 - 2.模杯圍面布是出紙格的款式尽量在棉杯上加厄位,特別情况给不了扼位需給尺寸.
 - 3.棉围款需在面杯及棉杯上增加刀口.
- 1.foam cup and shell cup both are mould cup,besides,shell cup has half-moon lace,add notch at foam cup btm edge to follow lace.Such as picture 1. shows.
 - 2.add notch at foam cup for this special style with shell/foam cup pattern,if cannot allow notch,then need to give relative measurement.
 - 3.add notch both at shell/foam cup for foam bra style.


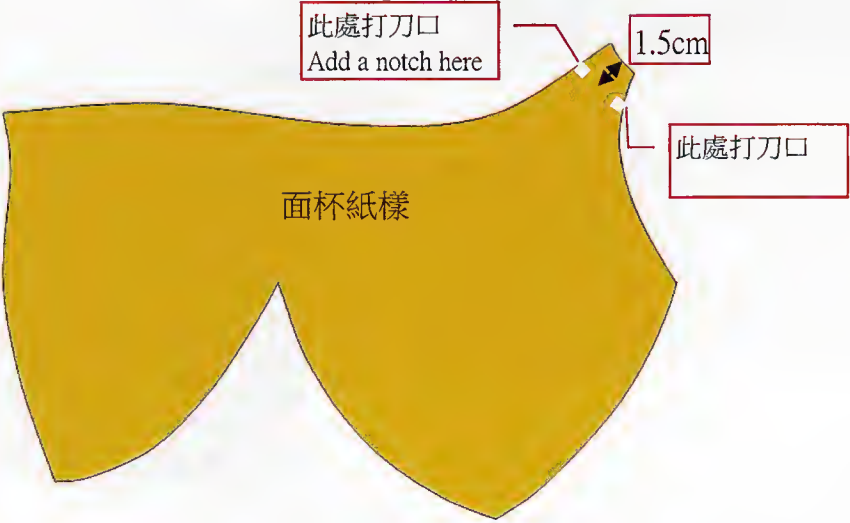


圖1.picture 1.



在棉杯上增加對花邊的厄位
Add a notch here to follow lace.

備注說明Remarks:

標準概述:	面杯耳仔位增加对棉杯耳仔边的扼位
Standard summarise :	Add a notch at loop position when making the shell cup pattern
執行日期:	2012年4月19日
Term of expiration date:	14-Jun-12
跟進人員:	紙樣組長/辦房車間
Follow-up staffs:	pattern team leader/sewing floor in sample room
標準說明: Standard explanation : 面杯出紙樣耳仔位統一增加对棉杯耳仔边的刀口.(限耳仔位棉边距面布边1.5cm的款式增加) Shell cup has relative pattern,add notch at shell cup loop to follow foam cup loop(just for the style that foam edge at cup loop is at 1.5cm from shell fabric edge).	
	
	
備注說明Remarks: 加凸刀口還是凹刀口須按布料而定。 The type of notch depends on fabric type.	

標準概述:	面杯縮折款式的棉杯位厄位要求
Standard summarise :	Noth request of shell faibric has been shirred.
執行日期:	2012年4月19日
Term of expiration date:	14-Jun-12
跟進人員:	紙樣組長/辦房車間
Follow-up staffs:	Pattern team leader / Sewing floor in sample room

標準說明:

Standard explanation :

有下扒款面杯有縮折的款式,統一在棉杯靠雞心的碗圈位上增加一個對面杯縮折的扼位.(此類款式盡量給扼位,特別情況給不了扼位需給尺寸)

For the style with cradle and shell cup has been shirred,add a notch at foam cup btm close to gore so that follow shell cup shirring place.(try adding notch for this style,if cannot,give measurement)

款式圖例 Style example:



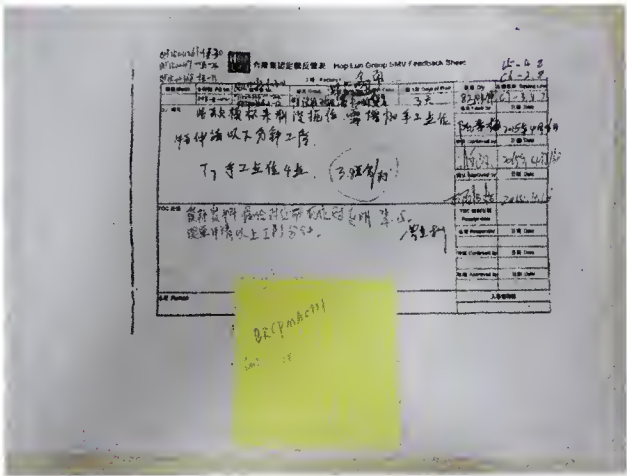
在模杯上增加厄位對面杯縮褶位.
add a notch at foam cup so that
follow shell cup shirring place.

**備注說明Remarks:**

標準概述:	新款模杯增加厄位
STANDARD BRIEF:	Add notch on new mould cup
執行日期:	2015年4月28日
EXCUTION DATE:	28-Apr-15
跟進人員:	紙樣組長/車間
FOLLOW-UP STAFFS:	Paper pattern/ Sewing room

標準說明STANDARD EXPLANATION:

關於新款模杯上需要增加扼位的,討論統一在那個環節增加(參考008-P-00129款)
 Discuss which link need to add notch on new mould cup.






備注說明Remarks:

IE在報價時需考慮點位分鐘. 駁批的款能在模杯資料上第一水給扼位尺寸的就要給, 不能給的款在下水增加扼位尺寸.
 IE need to consider the PT minute. Please give the notch size for the first time. Add the notch size for next time if the first time unavailable

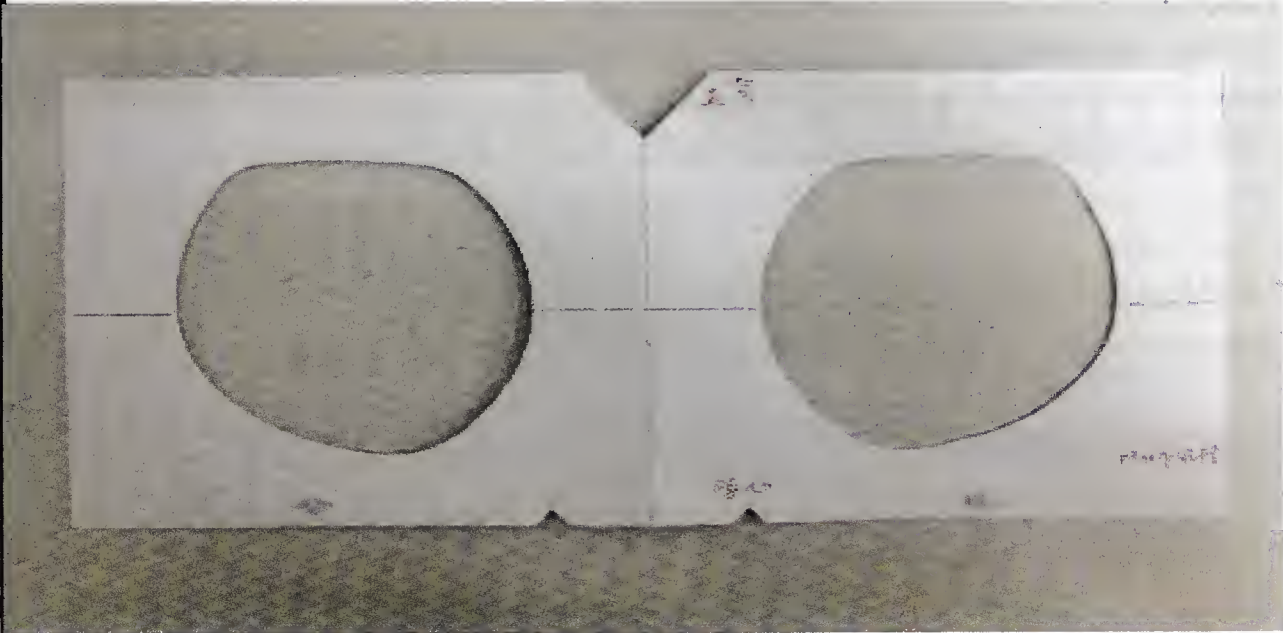


合隆技術標準指引

HopLun Technical standard direction

標準概述:	模棉杯杯邊扼位
Standard summarise :	Notch of mould cup
執行日期:	2018年9月26日
Term of expiration date:	26-Sep-18
跟進人員:	模杯板房/紙樣組/辦房車間/大貨技術員
Follow-up staffs:	Mould sample room/Pattern/Workshop/Technician
標準說明:	
Standard explanation :	
統一所有模杯款杯邊的扼位要打在正面(註:客人指定的模杯要求除外)	
Make all mould cup neckline notch on the right side, except guest appointed mould cup.	
<div><div>模棉杯正面 right side of mould cup</div></div> <div><div>模棉杯反面 wrong side of mould cup</div></div>	
打扼位效果圖.	
Effect picture	
<div>統一模棉杯杯邊扼位要打在正面</div> <div>Make all mould cup neckline notch on the right side</div> 	
備注說明 Remarks:	
請注意,之前有統一要求杯邊扼位長度只有3MM.	
Have unified the length of neckline notch only 3MM	

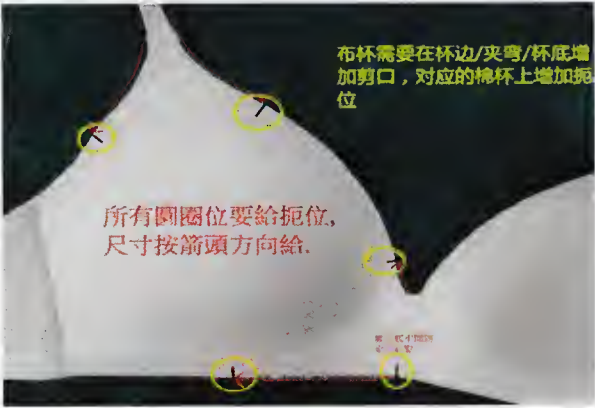

HopLun Technical standard direction

標準概述:	統一防水布加上呢位分上杯邊或夾彎位
Standard summarise :	Increase notch at waterproof
執行日期:	2017年6月15日
Term of expiration date:	15-Jun-17
跟進人員:	模杯組/紙樣組/辦房車間/大货技术员
Follow-up staffs:	Mould sample room/Pattern/Workshop/Technician
標準說明:	
Standard explanation :	
<p>統一防水布按下圖樣板加上呢位分上杯邊或夾彎位</p> <p>Increase notch at waterproof to distinguish front neckline or armhole as below sketch</p>	
	
備注說明 Remarks:	



合隆技術標準指引

HopLun Technical standard direction

標準概述:	統一連體模杯有耳仔及無耳仔運反款的掙位
Standard summarise :	Unify notch of siamese mould cup
執行日期:	2018年3月22日
Term of expiration date:	22-Mar-18
跟進人員:	跟單組/紙樣組/模杯房/辦房車間/大貨技術員
Follow-up staffs:	Merchandising/Unit Consumption/Workshop/Technician
標準說明:	
Standard explanation :	<p>統一連體模杯有耳仔的,沒有耳仔的款 For siamese mould cup with apex or without apex</p> <p>1:紙樣師傅在模杯資料上都要加棉杯掙位尺寸.(有耳仔的跟左圖給掙位,無耳仔的杯型,見下圖,杯邊中間要容面布的就按需要容的地方打兩個掙位及剪口對,不需要容的就在中間位置打一個掙位及剪口對,其它部位參照有耳仔的給掙位)</p> <p>Pattern maker should increase cup notch size on mould cup data. Offer notch if have apex; cup without apex need shrink in middle of neckline,then mark 2 notch at shrinkage position; cup without apex no need shrink to sew, then mark 1 notch in the middle.</p> <p>Notch of other position follow apex style.</p> <p>2:面杯由模杯房紙樣師傅按實際位置增加剪口.</p> <p>Increase shell fabric notch according to actual position by pattern maker in mould sample room</p> <p>3:翻單款由營業大貨跟單通知板房配合增加.</p> <p>Bulk merchandiser inform sample room to increase it for repeat order</p>
<div><div></div><div></div></div>	
備注說明 Remarks:	
可參考056-T-00052/52B款 056-T-00052/52B for reference	



合隆技術標準指引

HopLun Technical standard direction

4、物料標準類

Material Standard

4-1、紋路標準

Grain standard

合隆技術標準指引

HopLun Technical standard direction

標準概述:	雪紡布料做荷葉邊的捆條紋路
STANDARD BRIEF:	Grain Line Of Binding When Using Chiffon As Frill
執行日期:	2011年8月16日
EXCUTION DATE:	16-Aug-11
跟進人員:	紙樣組長/車間總指導
FOLLOW-UP STAFFS:	Pattern Team Leader/ Sewing Team Leader

標準說明STANDARD EXPLANATION:

雪紡布料做荷葉邊的捆條紋路為布邊紋。

Grain line of binding is straighted cutting when using chiffon as frill.



備注說明Remarks:

如果有特殊要求需提出, 並在跟蹤表上注明.

If with special requests, please indicate on the tracking table.

標準概述: Standard summarise :	捆条纹路及宽度的標示標準 When using binding,binding grain and width need to be marked.
執行日期: Term of expiration date:	2011年11月28日 28-Nov-11
跟進人員: Follow-up staffs:	紙樣組長 Pattern team leader
標準說明: Standard explanation :	所有捆条需写清楚捆条纹路及宽度,如有更改需签上更改日期. binding grain and width need to be marked on material card,and if any change, change date is needed.

1.在色卡上填寫捆條資料 Filling binding information on material card :

大料>Main Fabric	大料>Main Fabric	大料>Main Fabric
16MM布 25MM布邊紋 邊紋(意粉 (茨車,單復口) 帶)	12MM布 邊紋	19MM布 邊紋
所用部位 Component: 杯位/比位/上比連夾 至經帶捆/雞心意粉帶蝴蝶結	所用部位 Component: 雞心底,捆碗	所用部位 Component: 軟紗(雞心頂)
物料名称/封度 Material Nature/Width: DL260/147CM	物料名称/封度 Material Nature/Width: SH60G 20定形紗/147CM	物料名称/封度 Material Nature/Width:
捆条纹路/封度 Grain Line/Width:	捆条纹路/封度 Grain Line/Width:	捆条纹路/封度 Grain Line/Width:

2.在色卡上修改捆條封度 Change the width of binding on material card:

大料>Main Fabric	大料M
16MM 2011/11/30 25MM 布邊紋	
所用部位 Component: 杯位/比位	所用部
物料名称/封度 Material Nature/Width:	物料名
捆条纹路/封度 Grain Line/Width:	捆条纹

有更改時需簽上更改日期.
Pls add the date if any change.

備注說明Remarks:

合隆技術標準指引

HopLun Technical standard direction

標準概述:	隱形捆碗款式的定型紗紋路使用標準
STANDARD BRIEF:	The Standard Of Stiff Lining's Grain Line Of Invisible Wire Casing Bra
執行日期:	2011年4月6日
EXCUTION DATE:	6-Apr-11
跟進人員:	車間總指/紙樣組長
FOLLOW-UP STAFFS:	Sewing Line Leader/Pattern Team Leader

標準說明STANDARD EXPLANATION:

隱形細碗位的定型紗網，之前有出過一份資料為用縱紋，現在統一改用布邊紋. 如下圖3.

The stiff lining of invisible wire casing, Currently,pls use lengthwise instead of biaswise before,see pict. 3 below .

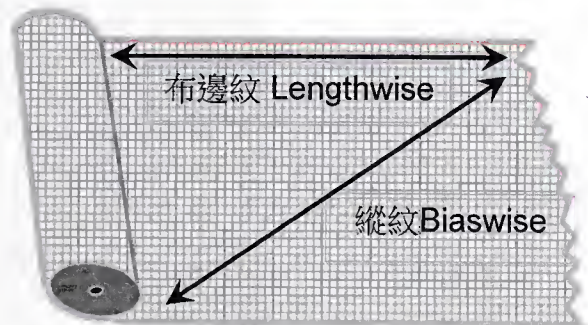
圖1. 隱形細碗款式

Pic1.The style of invisible wire



圖2. 定型紗紋向圖

Pic 2.The grain line of stiff lining



貼肉面



圖3.定型紗新做法: 布邊紋

Pic3.New method of making stiff lining:straight

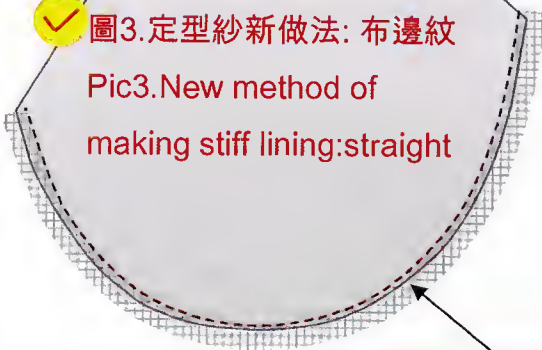
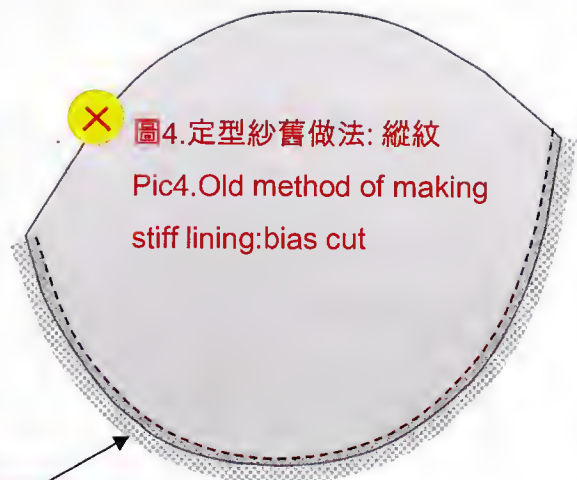


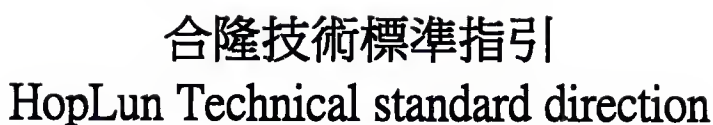
圖4.定型紗舊做法: 縱紋

Pic4.Old method of making stiff lining:bias cut



定型紗落於杯底貼肉面
Sewing the stiff lining on

備注說明Remarks:



標準概述:	模杯防水布紋路
STANDARD BRIEF:	The grain of mould cup waterproof
執行日期:	2014年11月25日
EXECUTION DATE:	25-Nov-14
跟進人員:	紙樣組長/紙樣技術員
FOLLOW-UP STAFFS:	Paper pattern/Technician

標準說明STANDARD EXPLANATION:

模杯中層防水布紋路事宜：

- 1) 模杯資料上沒有註明中層防水布的紋路的,按棉杯防水布布紋。
- 2) 模杯資料有註明防水布布紋的按模杯資料上註明紋路

Notice: the grain of mould cup water-proof fabric:

- 1) Mould cup data does not indicate the grain of water-proof fabric, please make it according to the grain of water-proof fabric of foam cup.
- 2) Mould cup data indicates the grain of water-proof fabric, please note it.

備注說明Remarks:



4、物料標準類 Material Standard

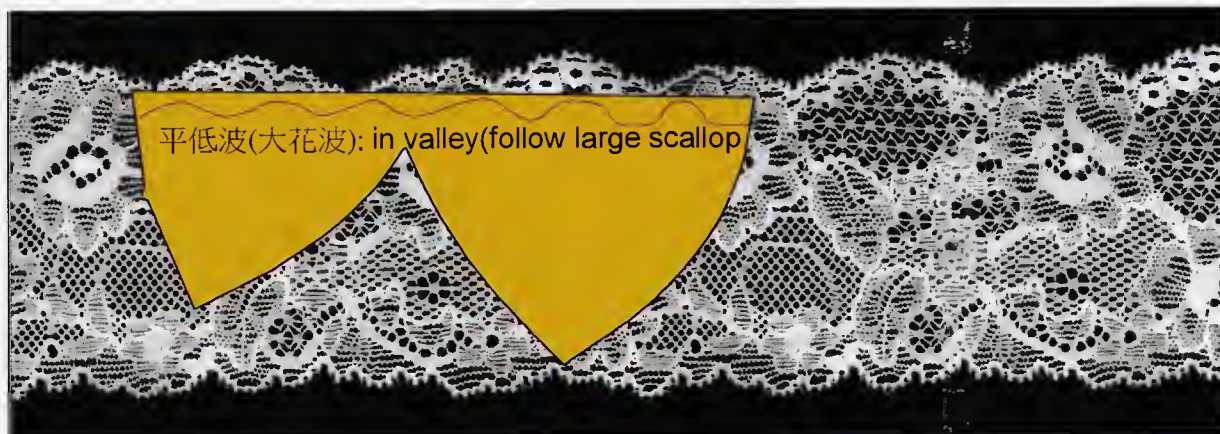
4-2、花邊標準 Lace standard

標準概述:	大小雙波花邊的紙樣標示
STANDARD BRIEF:	The Patterning Sign Of Large Or Small Double Valley Lace
執行日期:	2011年11月28日
EXCUTION DATE:	28-Nov-11
跟進人員:	紙樣組長/核算員
FOLLOW-UP STAFFS:	Pattern Team Leader / Material Reckoner

標準說明STANDARD EXPLANATION:

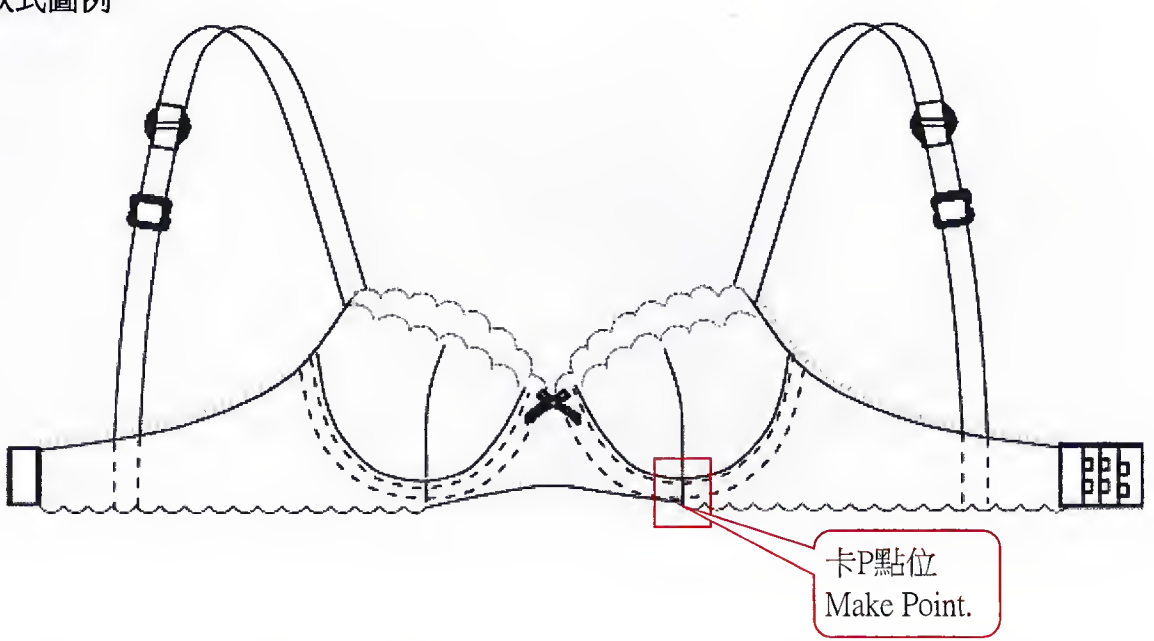
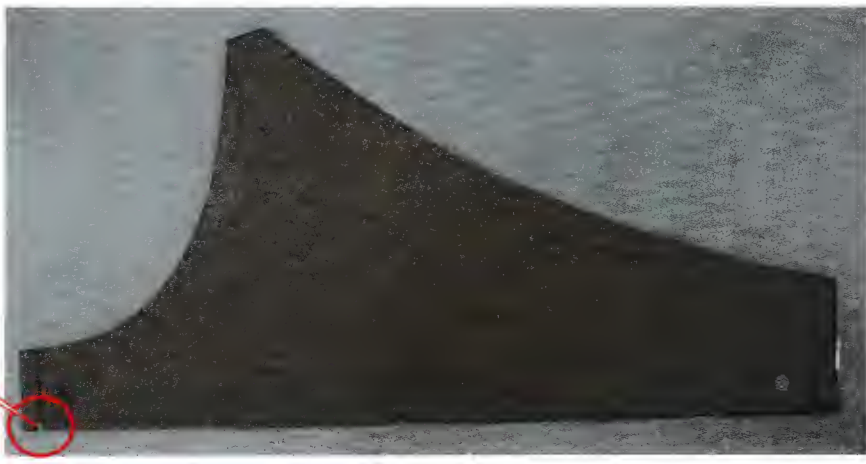
當花邊的兩邊花波大小不相同時,需在紙樣上注明是平小花波或平大花波.

When lace scallop of both sides are in differ,pls indicate clearly whether to follow small scallop or large.



備注說明Remarks:

標準概述: STANDARD BRIEF:	花边纸样要求 Rqts of paper pattern of lace
執行日期: EXCUTION DATE:	2011年11月28日 28-Nov-11
跟進人員: FOLLOW-UP STAFFS:	紙樣組長 Pattern team leader
標準說明STANDARD EXPLANATION:	
<div>1、花边纸样需建立水平布纹线,利于电脑花边排唛。 In order to arrange marker planning easily ,paper pattern of lace should have parallel fabric grain line.</div> <div></div> <div>2、當花邊款式,紙樣不是花圖的,是平低波出紙樣時,一端寫的卡P點,另一端是保持高度時,紙樣上不可有平低波的描述 When the lace style is a paper pattern, not a lace pattern, when the paper pattern is a flat valley, one end is the card P point, and the other end is to keep the height, the paper pattern cannot have a description of the flat valley.</div> <div>3、面層是花邊平低波出紙樣的,且有裡布的款式,紙樣上不可以寫保持高度 The surface layer is a paper pattern of flat valley lace, and the style has a lining, the paper pattern cannot write to keep the height.</div> <div>4、當花邊款式,紙樣是平低波出紙樣時,某一端需保寬度的,在保寬度一端止口位打上刀口區分並注明保持寬度的描述 When the lace style is a paper pattern of flat valley, one end needs to keep the width, and a knife edge is marked at the end of the width to distinguish and describe the width.</div> <div>3. Shell that is lacy and aligns with valley is made into paper pattern, and paper pattern can not write "keeping the same height" the style with lining</div> <div></div> <div>5、花邊是雙波的且兩邊波位,高低波相差1CM以上,建議紙樣小花邊平低波,大花邊位平高波出紙樣並有斜度,目的是因為如果都平低波出紙樣,花邊寬度大的易裁剪角度不標準,(例 458-L-00162)</div> <div></div> <div>Lace is 雙波的, and for 2 sides of scallop, there is more than 1CM 相差 between high scallop and valley. Suggesting that small lace of paper pattern aligns with valley, and big lace 平高波 and should be 有斜度的, the purpose is that it is not standard for wide lace to cut angles if paper pattern aligns with valley.</div> <div>6、花邊是出紙樣的,需駁花邊的部位,紙樣平低波 When the lace is a paper pattern, the part where the lace is needed, the paper pattern is a flat valley.</div> <div></div> <div></div>	
備注說明Remarks:	

標準概述:	有下扒圍款下比花邊卡p點的標準
STANDARD BRIEF:	Stand Of Cutting P Point For The Cradle Bra With Lace
執行日期:	2012年7月31日
EXCUTION DATE:	31-Jul-12
跟進人員:	車間總指導/紙樣組長
FOLLOW-UP STAFFS:	Sewing Team Leader / Pattern leader
標準說明Standard explanation : 如下圖款式的圍款,后比的花邊(如需卡P點的花邊)紙樣P點卡在下扒位。 As the following picture,lace on back wing (if needs to cutp point), the P point should be cut at the cradle.	
款式圖例  <p>卡P點位 Make Point.</p>	
紙樣標示  <p>卡P點位 Make Point.</p>	
備注說明Remarks:	

合隆技術標準指引

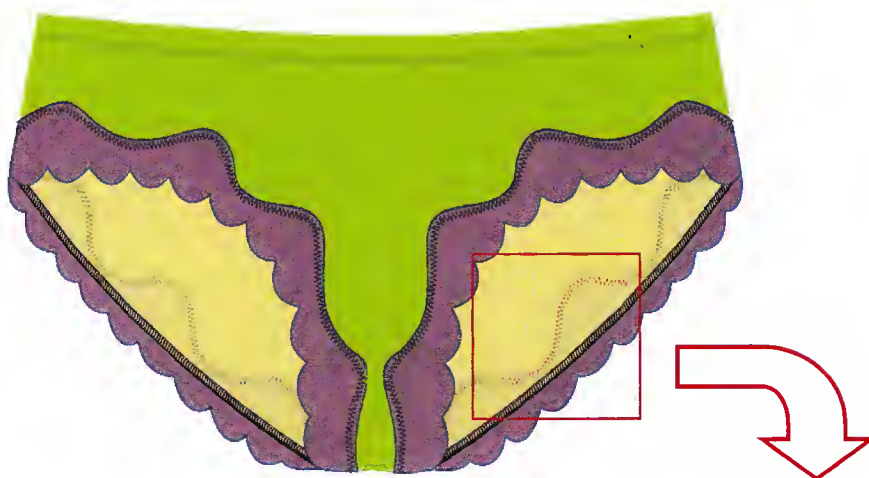
HopLun Technical standard direction

標準概述:	會散口的布料面配花邊款式的車縫做法
STANDARD BRIEF:	Standard Sewing Method Of Joining Lace At Fabric Easily Fray
執行日期:	2011年8月16日
EXCUTION DATE:	16-Aug-11
跟進人員:	辦房車間/技術員
FOLLOW-UP STAFFS:	Sample Room Workshop/Technician

標準說明STANDARD EXPLANATION:

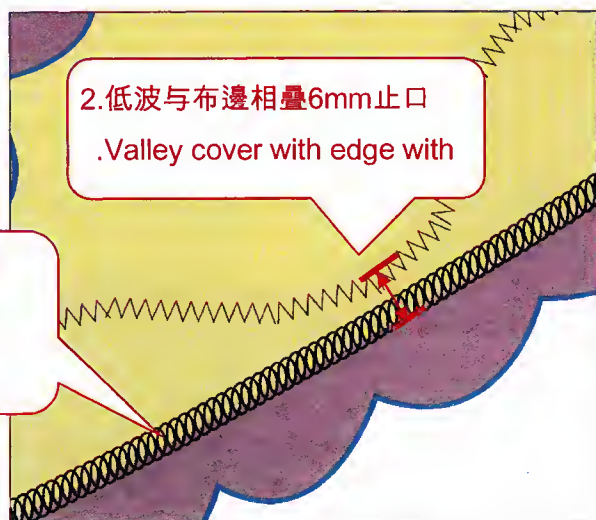
會散口的布料(例:色丁,雪紡,真絲,梭織布等等)面配花邊的款式,取消手工通花的工序,現做法如下:
When joining lace at fabric easily frayed(eq.satin,chiffon,real silk,jersey etc.),pls cancel the process of cutting fabric manually,Presently,the standard sewing method is as follows:

1.色丁布料面配花邊的款式Process of joining lace at satin fabric



2.低波与布邊相疊6mm止口
.Valley cover with edge with

1.先鉸骨鉸色丁布邊
O/L wrap satin fabric
edge first.



備注說明Remarks:

客人有特殊要求除外.

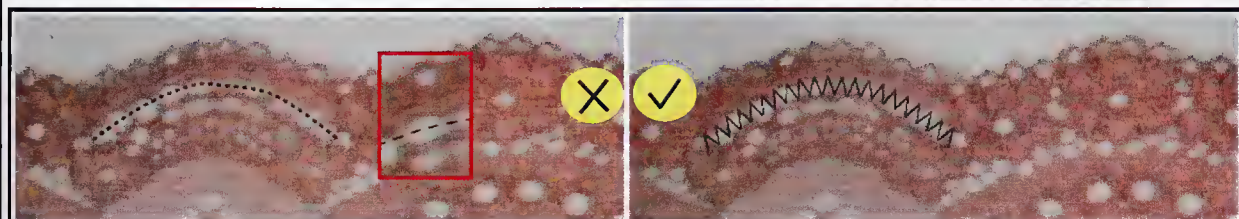
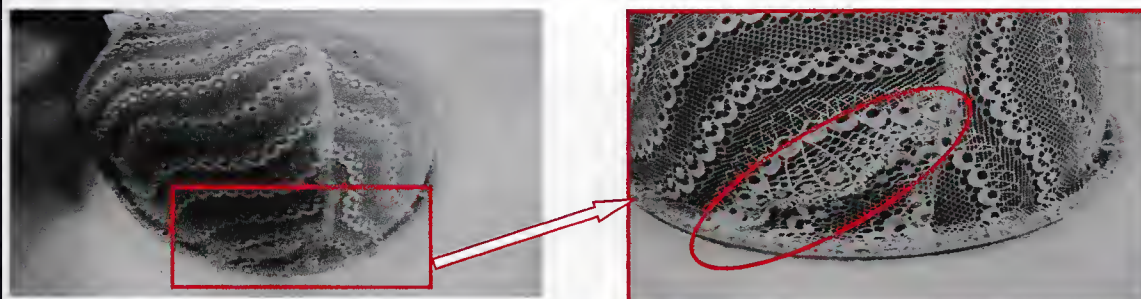
Except special reqts of customers,pls adopt this method.

標準概述:	圍款杯位駁花邊的車法(適用於有棉的杯位)
STANDARD BRIEF:	Sewing Method Of Joining Lace At Cup(Applying To The Cup With Foam)
執行日期:	2011年6月20日
EXCUTION DATE:	20-Jun-11
跟進人員:	車間總指導/技術員
FOLLOW-UP STAFFS:	Sewing line Leader / Technician

標準說明STANDARD EXPLANATION:

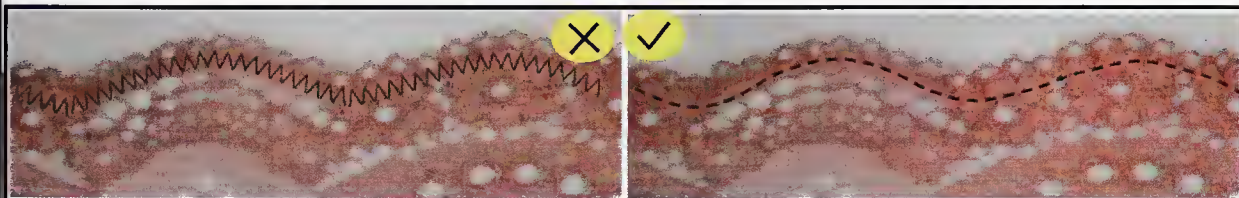
杯位花邊不夠大需接駁花邊時, 采取以下正確的標準車法.

If the lace at cup isn't large enough, need to be joined with lace,pls adopt the following standard sewing method:



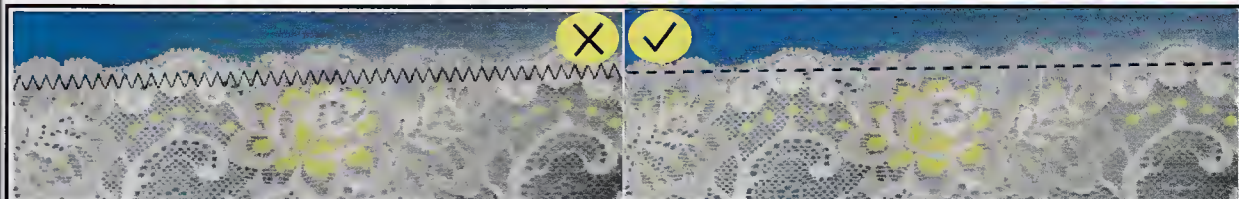
1. 當花邊的洞較大(一個花洞需兩針步)和花波高的, 需採用人字車的車法.

.When the hole of lace is big(need 2 stitches to sew one)and scallop is so high,need to use zag-zig sewing.



2. 當花邊的洞較小和花波高的, 需採用單針沿低波的車法

.When the hole of lace is small and scallop is high,need to adopt Single-needle sewing in valley.



3. 當花邊的洞較小和花波低的, 需採用單針沿低波的車法

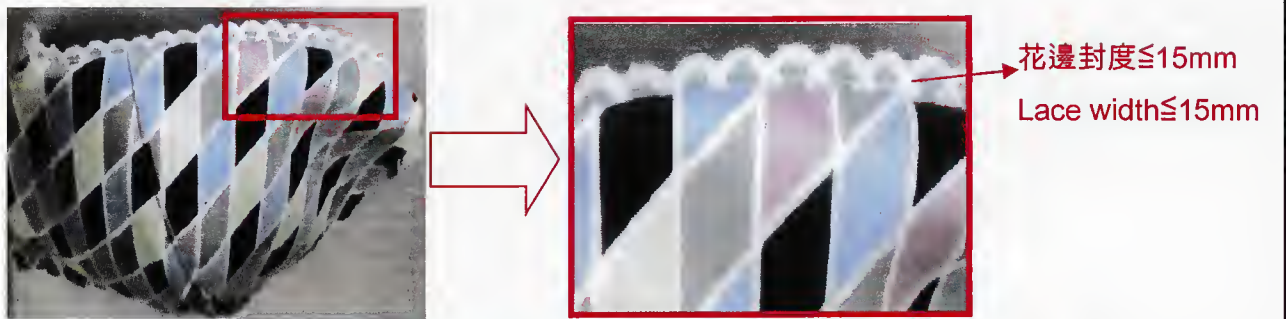
.When the hole of lace is small,also,scallop is low,need to adopt single-needle sewing in valley.

備注說明Remarks:

標準概述:	杯邊落細花邊的做法
STANDARD BRIEF:	How To Hang Thin Lace At Cup Edge
執行日期:	2011年8月16日
EXCUTION DATE:	16-Aug-11
跟進人員:	辦房車間
FOLLOW-UP STAFFS:	Sample Workshop

標準說明STANDARD EXPLANATION:
 對於杯邊落細花邊(封度 $\leq 15\text{mm}$),為了避免花波不易內扣,現統一做法是一次性在杯邊底用雙針車吊落花邊。
 For attaching thin lace(width $\leq 15\text{mm}$) on cup edge,to avoid curvling inwards,Now the standard sewing method is t/n attach lace on cup edge bottom by one time.

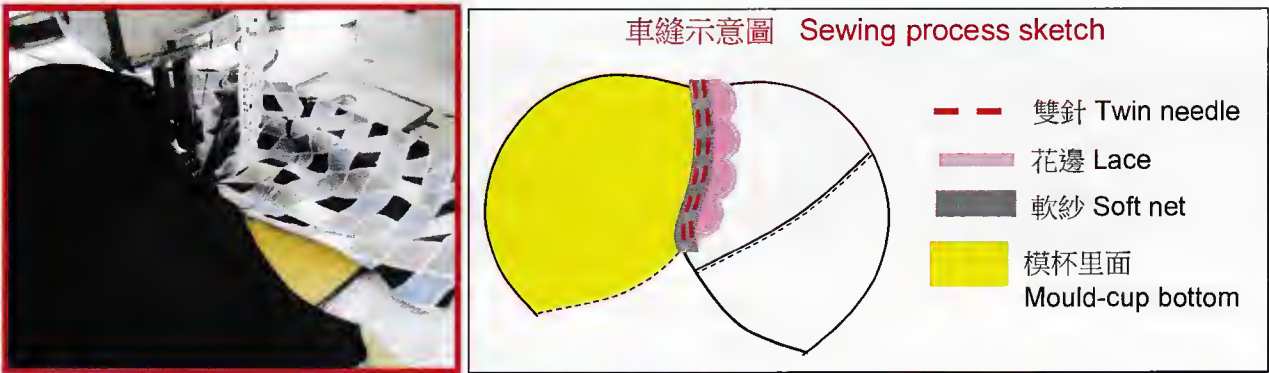
1.款式圖Style:



2.使用衣車說明 Instruction of using sewing machine:



3.車縫示意圖 Sewing process sketch



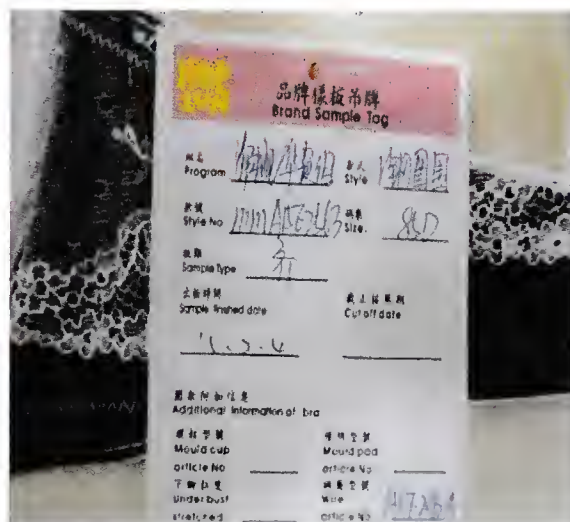
備注說明Remarks:
 該做法從即日新單開始,但客人有特別要求除外。
 Except special rqts of customers,this method will be adopted from now on.

標準概述:	P點統一出在心位
STANDARD BRIEF:	Unify to make P point at CF
執行日期:	2015年4月28日
EXECUTION DATE:	28-Apr-15
跟進人員:	紙樣組長/車間
FOLLOW-UP STAFFS:	Paper pattern/ Sewing room

標準說明STANDARD EXPLANATION:

面杯是花邊,杯頂有耳仔的款,現有的款花邊P點在心位,有的款在耳仔位.為方便大貨生產.工廠建議P點統一出在心位.(參考MMA15E2563款)

The style of bra is that shell cup is lacy and cup apex is looped. But now, the point P of lacy bra is at gore, and some of them is in the loop. In order to be convenient for stock production, factory suggests that point P is uniformly required to be at gore.(Take



備註說明Remarks:

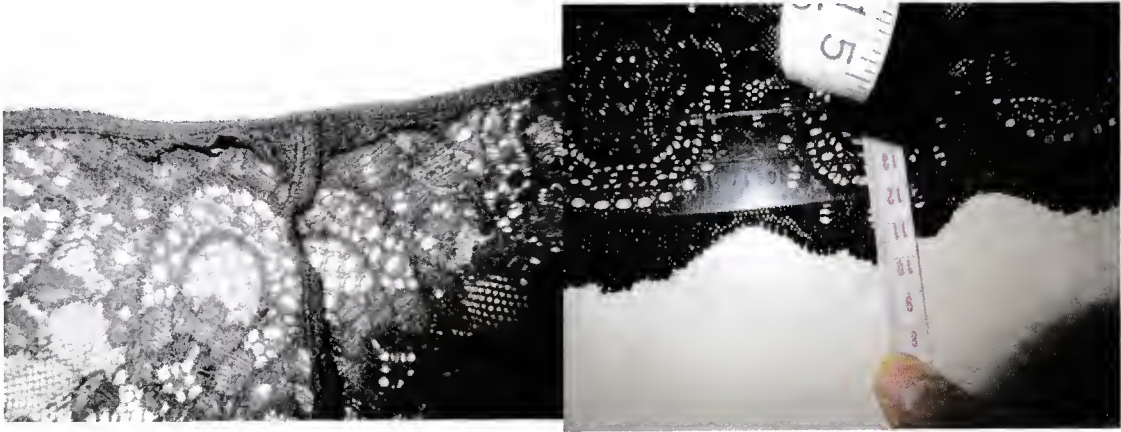
統一所有客以心位定P點.(從現在的新單開始)如有特殊款式需提前提出.(MM客SS15季已經出資料的款需技術員上MEMO通知工廠自行更改)

Unify all customers that point P is fixed at gore.(From now on, it will be adopted from new orders). It should be brought up in advance if there are special styles.(The style on data that has already printed out, MM客SS15季, needs technicians to use MEMO to inform factory to change by themselves.



合隆技術標準指引

HopLun Technical standard direction

標準概述:	小花邊是否通花 whether need to cut excess fabric under the lace of small
STANDARD BRIEF:	lace
執行日期:	2015年4月28日
EXCUTION DATE:	28-Apr-15
跟進人員:	辦房車間
FOLLOW-UP STAFFS:	Product line in sample room
標準說明STANDARD EXPLANATION:	
<p>針對花邊封度不夠高的,紙樣有出紙格駁花邊款.駁花邊是人字沿波車,花波大的完成子口 外露太多,討論是否通花,如通花限多高花波需要通花.(如071-N-00439款花波高度16MM 板沒有通花)</p>	
	
備注說明Remarks:	
板車間按實際情況決定做法,工藝跟開貨板寫工藝.	

標準概述:	用盡花邊低波封度
STANDARD BRIEF:	Use up valley width of lace
執行日期:	2013年10月22日
EXCUTION DATE:	22-Oct-13
跟進人員:	紙樣組長/紙樣技術員
FOLLOW-UP STAFFS:	Paper pattern/Technician
<p>標準說明STANDARD EXPLANATION:</p> <p>對於出紙格時需要用盡花邊低波封度的且一邊要裁掉花波，另一邊需駁花邊的款，如右圖需駁花邊款,出大塊紙格時比花邊封度做小5MM出，.將小塊駁花邊紙格加大5MM，以方便大貨裁，如回來有偏小情況可就得到。</p>	
	
備注說明Remarks:	



合隆技術標準指引

HopLun Technical standard direction

標準概述:	后比位花邊紙樣做法
STANDARD BRIEF:	Paper pattern of lace at back wing
執行日期:	2015年4月28日
EXCUTION DATE:	28-Apr-15
跟進人員:	紙樣組長/車間
FOLLOW-UP STAFFS:	Paper pattern/ Sewing room
標準說明STANDARD EXPLANATION:	
<p>后比位花邊紙樣要求平低波左右對稱裁，按紙樣裁完后花邊冒尖角，紙樣改為平高波可改善此問題。(參考071-N-00436款)</p> <p>Scallop of back wing on paper pattern is required to align with valley and symmetrically cut left and right. Lace at back will expose pointed angle after paper pattern's cutting. If paper pattern is modified aligns with high scallop, this problem can be solved. (Take 071-N-00436 as reference).</p>	
	
備注說明Remarks:	
<p>統一紙樣更新為平高波</p> <p>Update uniformly paper pattern to aligns with high scallop.</p>	

標準概述:	杯位花邊卡P點
STANDARD BRIEF:	Make P point at cup lace
執行日期:	2014年11月25日
EXCUTION DATE:	25-Nov-14
跟進人員:	紙樣組長/紙樣技術員
FOLLOW-UP STAFFS:	Paper pattern/Technician
<p>標準說明STANDARD EXPLANATION:</p> <p>針對杯位花邊需卡P點的款式,建議紙樣盡量將P點卡在雞心位(特殊款式除外 MMS15P0756款P點需在夾彎位),因心位為A區,此位折波影響外觀(例C8S5DS109 P點在夾位,008-N-00058在心位) 看款式而定.</p> <p>As for lacy cup needs to fix point P, suggesting that paper pattern try to put point P at gore. (Except for special style, MMS15P0756. The point P is required to be at underarm.) Because the gore is in A area, folding scallop in this part will influence the appearance. (For example, C8S5DS109, point P is at underarm. But 008-N-00058 is at gore). It depends on styles.</p>	
	
備注說明Remarks:	

合隆技術標準指引

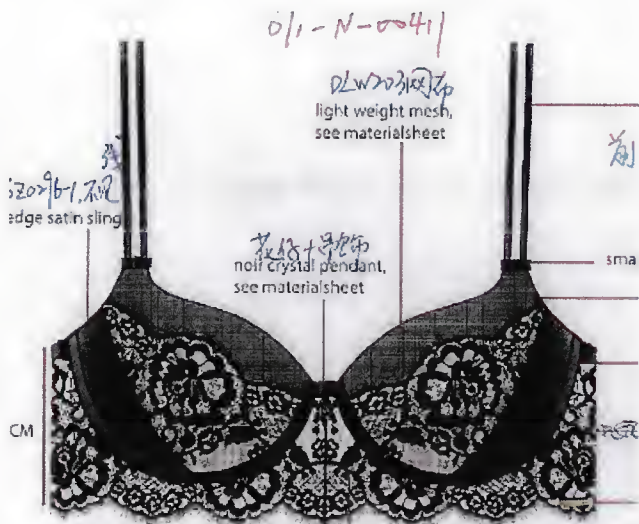
HopLun Technical standard direction

標準概述:	杯位花邊是否需卡花
STANDARD BRIEF:	Whether need to fixed the lace at cup
執行日期:	2014年11月25日
EXCUTION DATE:	25-Nov-14
跟進人員:	用量
FOLLOW-UP STAFFS:	Unit Consumption Team

標準說明STANDARD EXPLANATION:

杯位花邊是否需卡花(第1次見客板杯位卡花)

Whether it is necessary to fix the lace at cup. (The sample of cup should be fixed lace while meeting a customer for the first time.)



- 1.花邊 SWP452A 24CM 闊*每段 295CM 長 下杯/雞心/前比 0.73M/件
- 2.色丁布 SZ0296-1 122/127CM 杯側雙層 0.03M/件
色丁布 SZ0296-1 122/127CM 前肩帶捆 0.0151M/件
- 3.網布 DLW203 147/152CM 後比裡 0.0185M/件
- 4.網布 DLW401 147/152CM 上杯 0.0175M/件

備注說明Remarks:



合隆技術標準指引

HopLun Technical standard direction

標準概述:	花邊出紙格的紙樣做法
STANDARD BRIEF:	Paper pattern of lace pattern
執行日期:	2015年6月1日
EXCUTION DATE:	1-Jun-15
跟進人員:	紙樣組長
FOLLOW-UP STAFFS:	Paper pattern leader
標準說明STANDARD EXPLANATION:	
<p>所有花边出紙格的款，纸样两边要求对称的，工廠建议纸样中间给画一个中间线，这样方便裁床控制左右對稱。C8F5PT162款.</p> <p>As for all styles with lace, the 2 sides of paper patterns are required to be symmetrical. Factory suggests that drawing a medium line in the middle of paper patterns, which is convenient for cutting tables to control the symmetry between left and right. Style C8F5PT162.</p>	
備注說明Remarks:	

標準概述:	花邊可以出吊落的,盡量出吊落後按實樣修剪 Try to hand&attach the lace if possible and cut according to actual paper pattern
STANDARD BRIEF:	
執行日期:	2015年4月28日
EXCUTION DATE:	28-Apr-15
跟進人員:	紙樣組長/車間
FOLLOW-UP STAFFS:	Paper pattern/ Sewing room
標準說明STANDARD EXPLANATION:	
<p>如445-N-00251B款比布花边款式.工廠建議花邊可以出吊落的,盡量出吊落後按實樣修剪角度.</p> <p>For example, fabric with lace, 445-N-00251B. Factory suggests that lace can be made into hang and attachment, and try to cut angle according to the actual after hanging and attaching.</p>	
	
備注說明Remarks:	
統一花邊可以出吊落的,一定要出吊落並給修剪實樣,有疑問的可提出討論.	

標準概述:	花邊款式註明固定位置及波位裁
STANDARD BRIEF:	Remark the fixed location and cut along scallop for lace styles
執行日期:	2014年3月20日
EXCUTION DATE:	20-Mar-14
跟進人員:	紙樣
FOLLOW-UP STAFFS:	Paper pattern

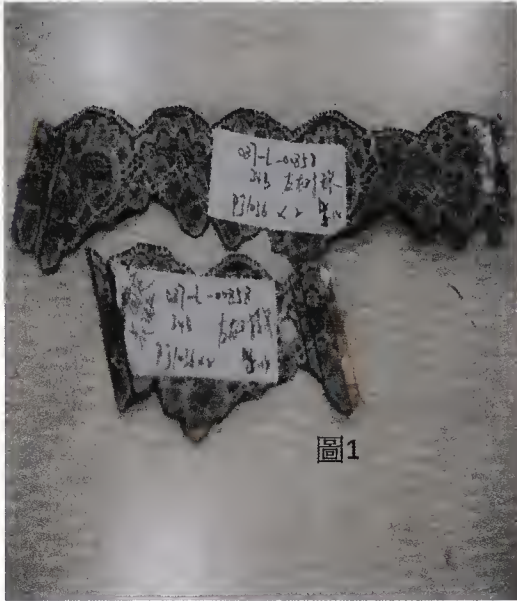

標準說明STANDARD EXPLANATION:

針對花邊款式紙樣給的是貼花邊圖的,因大貨來料花邊波形及間距會與紙樣上貼的波小小不相符,統一紙樣上注明固定位置及波位裁

For style with lace, paper pattern need stick lace pattern. Because lace shape of bulk production and distance are inconsistent with it on paper pattern. It should remark the fixed position and cut according to scallop shape.



備註說明Remarks:

標準概述:	電腦存花波
STANDARD BRIEF:	Keep scallop to computer
執行日期:	2014年7月3日
EXCUTION DATE:	3-Jul-14
跟進人員:	紙樣組長/紙樣技術員
FOLLOW-UP STAFFS:	Paper pattern leader/Technician
<p>標準說明STANDARD EXPLANATION:</p> <p>紙樣是出花圖的,需用電腦讀圖將花波存到電腦裡,如附圖(2)的效果</p> <p>Paper pattern is 出花圖的.And it needs to read images by using computer to save lace scallop into computer. For example, picture 2.</p> <div>   </div>	
<p>備注說明Remarks:</p>	

標準概述:	雞心花邊紙樣
STANDARD BRIEF:	Paper pattern of CF lace
執行日期:	2014年7月3日
EXCUTION DATE:	3-Jul-14
跟進人員:	紙樣組長/紙樣技術員
FOLLOW-UP STAFFS:	Paper pattern leader/Technician

標準說明STANDARD EXPLANATION:

雞心花邊紙樣無特別尺寸不要出花圖,因為特別難左右對稱,只需在紙樣上寫明:平低波,中間注明固定高波位,左右對稱即可

The lace at gore on paper pattern does not 出花圖 if there is no special size. Because it is too difficult to symmetrize left and right,so, it only notes on paper pattern: aligning with valley, noting fixed high scallop in the middle of paper pattern and symmetrizing left & right.



備注說明Remarks:

合隆技術標準指引

HopLun Technical standard direction

標準概述:	前側骨位及不受力部位吊落小花邊的做法
STANDARD BRIEF:	Sewing method of attach small lace at front side seam and
執行日期:	2013年10月22日
EXCUTION DATE:	22-Oct-13
跟進人員:	紙樣技術員/辦房車間
FOLLOW-UP STAFFS:	Technician/Product line in sample room

標準說明STANDARD EXPLANATION:

如前側骨位(及不受力部位)需要吊落小花邊,現統一用單針車吊落(完成線路要好,單會吊落花邊線要有1:1.3倍的拉度)成品完成后不用拉斷線.)

s/n 1/s hand & attach small lace if need to attach samll lace at front side seam and some not stress position. It doesn't need to crack stitch when finishing(There is 1:1.3 extension and nice tension when using S/n 1/s attach lace)



備注說明Remarks:



4、物料標準類

Material Standard

4-3、其它物料標準

Other material standard

合隆技術標準指引

HopLun Technical standard direction

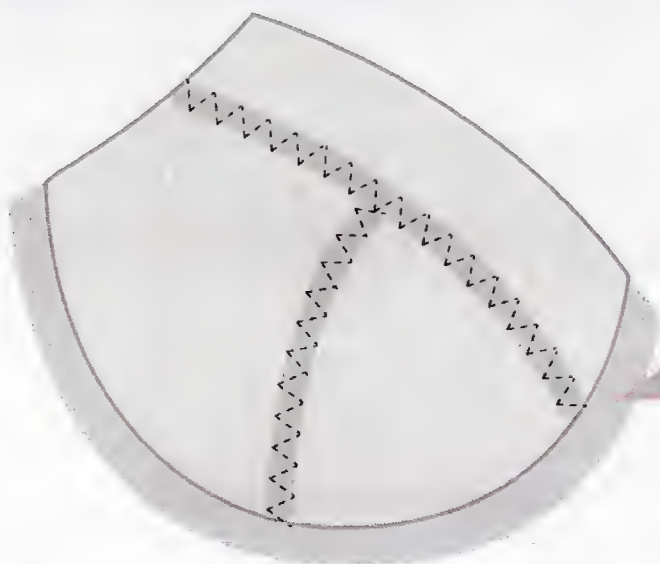
標準概述:	倒網碗棉圍款碗底定型紗網封度的標準
STANDARD BRIEF:	Standard Usage Of Fixed Net Binding For Padded Bras (Seam allowance towards cup when sewing wire casing on)
執行日期:	2011年1月21日
EXCUTION DATE:	21-Jan-11
跟進人員:	紙樣組長
FOLLOW-UP STAFFS:	Pattern Team Leader
標準說明STANDARD EXPLANATION:	

1. 款式圖: 棉圍倒網碗

Example of style: padded bra sew wire casing on cup btm(seam allowance towards cup)



2. 網碗位定型紗用法 The usages of attaching stiff lining binding at wire casing



定型紗網,切布邊
紋12mm (fixed
lining binding, cut
length wise

備注說明Remarks:

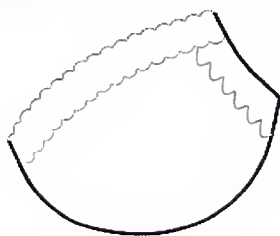
標準概述:	面杯需要加裝飾物時需在模杯資料上標示清楚
STANDARD BRIEF:	Mark Clearly On The Mould Cup Data When Top Cup Needs Decorations
執行日期:	2011年4月6日
EXCUTION DATE:	6-Apr-11
跟進人員:	紙樣組長/模杯組
FOLLOW-UP STAFFS:	Pattern Team Leader / Mould Team

標準說明STANDARD EXPLANATION:

模杯面需搭配其它裝飾物的款式, 需在<<合迅技術發展中心模杯資料表>>的備注檔注明清楚.
If top cup needs decorations,we need mark clearly in the remark on < He Xun Technical Development Centre Mold-cup Information >.

1. 例款式圖a: 模面杯上先車花邊再笠棉的款式.

.Picture of style: s/n l/s attach cup shell on foam after attaching lace on cup edge.



杯邊和夾彎花邊車縫方法: 先將花邊車于面布后再笠棉.

The sewing method of lace on cup edge:s/n l/s attach cup shell on foam after attaching lace on cup edge.

在<<合迅技術發展中心模杯資料表>>備注欄注明其詳細做法和要求.

Mark the especial request in the form<<合迅技術發展中心模杯資料表>>

2. 例款式圖b: 模面杯上駁有裝飾物的款式.

.Picture of style:The style which has decorations on shell of mould cup .



面杯上需車裝飾物,杯邊只留止口0.8cm,夾彎只留止口0.5cm.

It needs to join decorations on top cup,so the allowance of cup edge is 0.8cm and the allowance of underarm is 0.5cm.

在<<合迅技術發展中心模杯資料表>>備注欄注明其詳細做法和要求.

Mark the especial request in the form

備注說明Remarks:

詳見附錄第3頁<合迅技術發展中心模杯資料表>

Details pls see Page 3<He Xun Technical Development Centre Mold-cup Information>

合隆技術標準指引

HopLun Technical standard direction

標準概述:	活動絲帶的尺寸標示
STANDARD BRIEF:	Measurment Of Active Lace
執行日期:	2012年7月31日
EXCUTION DATE:	31-Jul-12
跟進人員:	車間總指導/紙樣組長
FOLLOW-UP STAFFS:	Sewing Team Leader / pattern leader

標準說明Standard explanation :

當絲帶完成須有活動的容位時，紙樣員在寫尺寸表時必須提供**絲帶剪長**尺寸和**絲帶完成鬆度**尺寸，以便于車間控制成品的絲帶鬆度尺寸。

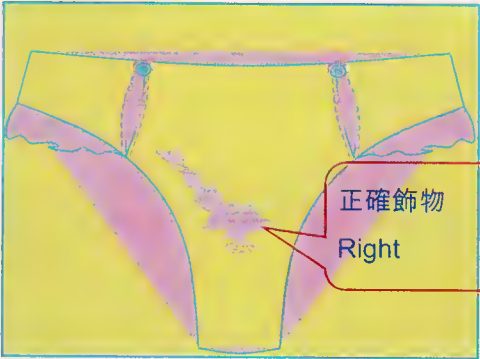
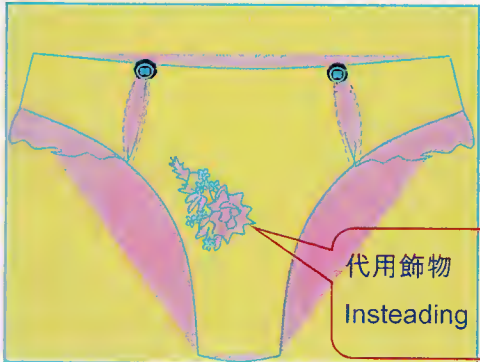
Regarding this style with removable ribbon,ribbon can remove after insert ribbon into lace holes.Pattern maker should allow the cut/ finished length of ribbon and how many the ribbon can remove for completed garments,which will be easy for sewing lines to control ribbon tension.

款式圖例



活動絲帶
removable ribbon.

備注說明Remarks:

標準概述: STANDARD BRIEF:	確認辦欠正確飾物的做法 How To Do When Firmed Samples Lack Of Correct
執行日期: EXCUTION DATE:	2011年6月20日 20-Jun-11
跟進人員: FOLLOW-UP STAFFS:	跟板員/紙樣組長/車間總指導 Pattern Team Leader / Sewing Team Leader
標準說明STANDARD EXPLANATION: 在做確認辦時, 當遇到欠花章/花仔/鈕扣/膠章等飾物時, 應採用代用料釘於正確的位置供車間參考. When making firmied sample , if it is lack of correct decorations: logo,bow,buckle ,plastic logo and so on, pls adopt insteading material to replace them at the right place for the reference of workshop.	
1.做法例子:Sample of making	
<div data-bbox="117 887 592 1245">  </div> <div data-bbox="696 982 1233 1112"> <p>正確要求: 正確飾物釘在正確的位置上. Correct requirement :the right decoration should be attached at the right place .</p> </div>	
<div data-bbox="117 1351 592 1712">  </div> <div data-bbox="696 1411 1246 1541"> <p>欠飾物時的做法:代用飾物釘在正確位置上. When lacking of decorations : place the insteading decorations at the right place .</p> </div>	
備注說明Remarks:	

標準概述:	丈根及肩帶有燙石的注意事項
STANDARD BRIEF:	Note of iron stone at elastic and strap
執行日期:	2014年7月3日
EXCUTION DATE:	3-Jul-14
跟進人員:	紙樣組長/紙樣技術員
FOLLOW-UP STAFFS:	Paper pattern leader/Technician

標準說明STANDARD EXPLANATION:

丈根及肩帶有燙石的,需將燙石位置做到實樣上.以便工厂在剪丈根及肩帶时可以避开燙石位置
 Elastics and straps with iron crytals need to be made into actual pattern, which is convenient for factory to avoid iron crytals when they are cutting elastics and straps.



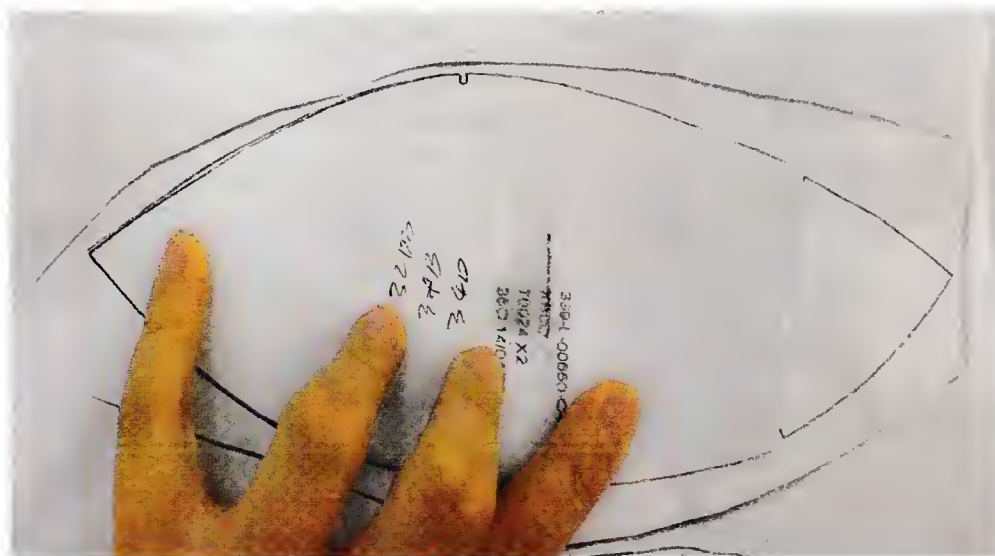
備注說明Remarks:

標準概述:	內袋面里紙樣
STANDARD BRIEF:	Paper pattern of inside pocket front and back.
執行日期:	2014年7月3日
EXCUTION DATE:	3-Jul-14
跟進人員:	紙樣組長/紙樣技術員
FOLLOW-UP STAFFS:	Paper pattern leader/Technician

標準說明STANDARD EXPLANATION:

要走內袋布線的款式,內袋面裡紙樣需大小一樣及剪口也需對齊,,因可以用自動點超聲波點內袋

For style with sewing cookie pocket fabric, paper pattern in cookie pocket should be same size, and notch is symmetric because the cookie pocket we use is 自動點超聲波點.



備註說明 Remarks:

標準概述:	勾圈需標明尺寸
STANDARD BRIEF:	Mark the size of Hook & Eye
執行日期:	2014年7月3日
EXCUTION DATE:	3-Jul-14
跟進人員:	紙樣組長/紙樣技術員
FOLLOW-UP STAFFS:	Paper pattern leader/Technician
標準說明STANDARD EXPLANATION:	
<div> <div>尺寸表上需寫上勾圈的闊度,以便工廠在車縫及檢查紙樣時可以早期控制勾圈位車縫寬度,前期已建議跟單在板單上注明勾圈的寬度</div> <div>It requires to write the width of hooks and eyes in size spec, which is convenient for factory to early control the sewing width of hooks and eyes while sewing and checking paper pattern.</div> <div>  </div> </div>	
備注說明Remarks:	



合隆技術標準指引

HopLun Technical standard direction

標準概述:	代用花仔做法
STANDARD BRIEF:	The sewing of substitutable bow
執行日期:	2015年6月1日
EXCUTION DATE:	1-Jun-15
跟進人員:	車間
FOLLOW-UP STAFFS:	Production line in sample room
標準說明STANDARD EXPLANATION:	
<p>開貨板花仔備註代用,後續做板用正確的花仔,做法完全不同.統一代用花仔外關和做法不可相差太大463-N-00122款</p> <p>Bow of production sample is remarked to be substitutable, but 後續 making sample, proper bow will be used, which is totally different from the former. Uniformly substitution of 花仔外關 and practice. There can not be much difference between them. Style 463-N-00122.</p> <div data-bbox="319 1139 1042 1694"></div>	
備注說明Remarks:	
<p>待Billy与跟單溝通後再決定.</p> <p>make a decision after the communication between Billy and documentary trackers.</p>	

標準概述:	印花布貼花圖要求
STANDARD BRIEF:	The demand of printing fabric
執行日期:	2014年3月20日
EXCUTION DATE:	20-Mar-14
跟進人員:	紙樣
FOLLOW-UP STAFFS:	Paper pattern
標準說明STANDARD EXPLANATION:	
<p>印花布貼花圖的,如果只需要左右對稱,不需要固定花形的,統一紙樣注明:左右杯花型要對稱無須固定花形</p> <p>Printing fabric is 花圖的. If left and right cups are only required to be symmetric and have no need to fix lace, uniformly note on paper pattern: the lace of left and right cups are symmetric and have no need to fix lace.</p>	
	
備注說明Remarks:	



合隆技術標準指引

HopLun Technical standard direction

標準概述:	同款不同料的做法
STANDARD BRIEF:	The method of same style but different material
執行日期:	2015年4月28日
EXCUTION DATE:	28-Apr-15
跟進人員:	紙樣組長/技術員
FOLLOW-UP STAFFS:	Paper pattern leader/Technician
標準說明STANDARD EXPLANATION:	
<p>關於一個款有淨色和印花兩種布料(普通印花且印花不區分方向的)做法不變.討論是否要用兩個款號.</p> <p>Discuss whether need to 2 style No. for the style with two kind of fabirc,one is pure fabric, and the other is printing(common printing and no direction).But the sewing method is the same.</p>	
備註說明Remarks:	
<p>待Billy与跟單溝通後再決定.</p> <p>Make a decision after communication between Billy and documentary trackers.</p>	



合隆技術標準指引

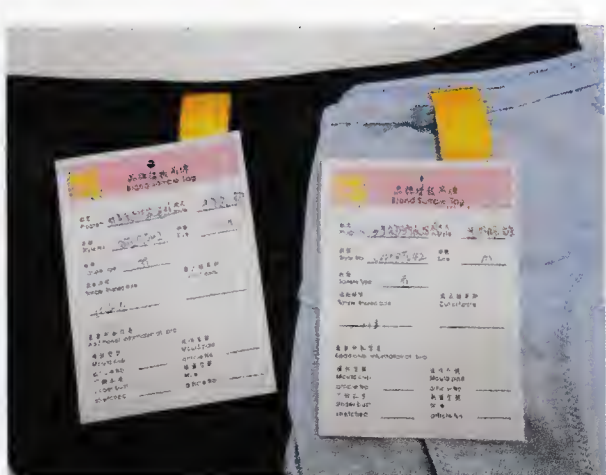
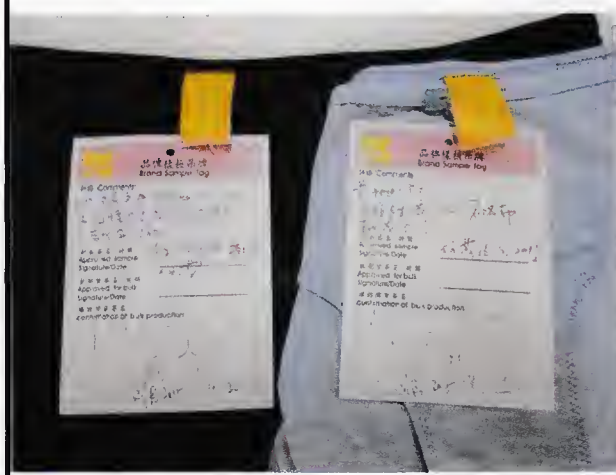
HopLun Technical standard direction

標準概述:	吊牌不寫備註
STANDARD BRIEF:	No remark on the handtag
執行日期:	2015年4月28日
EXCUTION DATE:	28-Apr-15
跟進人員:	辦房車間
FOLLOW-UP STAFFS:	Product line in sample room

標準說明STANDARD EXPLANATION:

開貨板上吊牌備註內容問題,之前月會有要求,不可以備註.(見附件現在吊牌上還是有很多評語)再次統一吊牌上不可以備註.

What is remarked on handtag of production sample can not be remarked because of the demand of monthly meeting. (Seeing the handtag from attached picture, there are a few of comments on handtags. Unify again that the comments on handtags are not allowed.)



備註說明Remarks:
統一吊牌上不可以寫任何備註內容.(除68客可以備註在外觀差的一件貨上用於板房留底及有附片做法的可備註)
Unify that there is no comments on handtag. Except 68 can be remarked on a sample that is in bad appearance, which is used for office copy. Also, the way of making can be remarked if there is an



合隆技術標準指引

HopLun Technical standard direction

標準概述:	二加工裁片印花的做法
STANDARD BRIEF:	The method of 2nd process cutting piece printing
執行日期:	2015年4月28日
EXCUTION DATE:	28-Apr-15
跟進人員:	紙樣組長/車間
FOLLOW-UP STAFFS:	Paper pattern/ Sewing room
標準說明STANDARD EXPLANATION:	
<p>所有裁片二加工印花款,完成後都會有縮水.如C8S5Pt587B款二加工印花後縮水了前浪位就對不到浪布刀口.工廠建議所有二加工裁片印花款出印花裁樣及增加印花後實樣,以便工廠核對.</p> <p>All 2nd process cutting piece printing will shrink after finishing. For example, C8S5Pt587B. After 2nd process cutting piece printing, front gusset is shrinked, which causes the mismatching with the notch of neaten fabric. Factory suggests that all 2nd process cutting piece printing is to be cut pattern and increase the actual pattern of printing, which is convenient for factory to check.</p>	
<div></div>	
備注說明Remarks:	
<p>3MM及以下的不用出實樣.3MM以上的統一增加印花後實樣.(紙樣師傅需在紙樣上備註清楚裁樣是裁床用和印花後實樣是車間用)</p> <p>It is no need to make actual pattern if it is less than 3MM.But uniformly increase actual pattern after printing if it is more than 3MM. (Pattern maker need to clearly remark that cutting patern should be used by cutting table or workshop on paper pattern.)</p>	



合隆技術標準指引

HopLun Technical standard direction

標準概述:	捆條注意事項
STANDARD BRIEF:	Binding note
執行日期:	2014年7月3日
EXCUTION DATE:	3-Jul-14
跟進人員:	查驗組
FOLLOW-UP STAFFS:	QC
標準說明STANDARD EXPLANATION:	
<p>色卡上注明了捆條的大小碼出口寬度,且是用雙針及坎車打捆條的,統一由查驗組負責在色卡上注明大小碼的針位</p> <p>Note that the width of binding size on colour atla, and binding is made by t/n l/s and c/s. The size of stitch is uniformly noted on colour atla by Inspection group.</p>	
備注說明Remarks:	



合隆技術標準指引

HopLun Technical standard direction

標準概述:	增加留長參考尺寸.
STANDARD BRIEF:	Add reference dimension for keeping thrum
執行日期:	2015年3月26日
EXCUTION DATE:	26-Mar-15
跟進人員:	紙樣組長/車間
FOLLOW-UP STAFFS:	Paper pattern/ Sewing room
標準說明STANDARD EXPLANATION:	
<p>445-N-00111A款 泳衣背心8593組.此款頸帶如板交叉穿於後中隧道內,完成後綁帶需按尺寸留長打蝴蝶結包裝出貨.建議類似款式紙樣師傅在尺寸表上增加留長打蝴蝶參考尺寸.</p> <p>445-N-00111A, swimwear empire seam 8593 group. This neck straps crossing in 後中隧道內 follow sample. It is necessary to outstretch and make bow tie according to sizes after finishing. And then pack it up and deliver. Suggesting that paper maker should increase length to make bow tie according to sizes in size spec.</p>	
<div></div>	
備注說明Remarks:	
待与工廠溝通後再討論.	



合隆技術標準指引

HopLun Technical standard direction


標準概述:	模杯款式要求
STANDARD BRIEF:	Demand of mould cup styles
執行日期:	2013年10月22日
EXCUTION DATE:	22-Oct-13
跟進人員:	紙樣組長/紙樣技術員
FOLLOW-UP STAFFS:	Paper pattern/Technician

標準說明STANDARD EXPLANATION:

模杯款式，是否需加加防水布，模杯资料統一跟足跟單開的板單做。
For the mould cup styles , need to follow up the order provided by merchandiser on whether need to add waterproof fabric and mould cup data

Option (if there is "✓" we should follow)		For which / 適用	For which / 適用
Option (if there is "✓" we should follow)		For which / 適用	For which / 適用
✓ Shell Cup Edge seam finish Seam allowance 11.11 cm		Shell fabric	For which / 適用
✓ Topcup Cup edge Raw edge		For which / 適用	For which / 適用
✓ Shell lining Cup edge seam allowance 11.11 cm		For which / 適用	For which / 適用
✓ Shell lining Underarm lean finish Seam allowance 11.11 cm		For which / 適用	For which / 適用
✓ Shell lining Underarm Raw edge		For which / 適用	For which / 適用
✓ Shell lining Underarm Seam allowance 0.7 cm		For which / 適用	For which / 適用
✓ Shell lining Underarm Seam allowance 11.11 cm		For which / 適用	For which / 適用
✓ Shell lining Underarm Raw edge		For which / 適用	For which / 適用
✓ Shell lining Cup insert Seam allowance 1 cm		For which / 適用	For which / 適用
✓ Overlap seam allowance between top cup edge and low cup		For which / 適用	For which / 適用
✓ Join seam allowance between top cup edge and low cup		For which / 適用	For which / 適用
Wire end distance 內徑: 12.7CM		Wire length 外徑: 22.3CM	Wire length 外徑: 22.3CM
75B	80B/75C	85B/80C/75D	90E/85D
90E	95E	100E	105E

備注說明Remarks:

標準概述:	燙石做法
STANDARD BRIEF:	The way of iron stone
執行日期:	2014年7月3日
EXCUTION DATE:	3-Jul-14
跟進人員:	紙樣組長/紙樣技術員/大貨資料組
FOLLOW-UP STAFFS:	Paper pattern leader/Technician/
標準說明STANDARD EXPLANATION:	
<p>當紙樣師傅自行標記燙石位置時,因紙樣上有手寫的字且蓋住了燙石的位置,黑白復印給跟單外發二加工時,無法看到燙石的位置,現統一由紙樣復印彩色效果及標記燙石的位置給下一個部門,另紙樣手寫字時,需避開燙石位置(因彩色復印成本大,暫時試行一個月)</p>	
	
備注說明Remarks:	



合隆技術標準指引

HopLun Technical standard direction

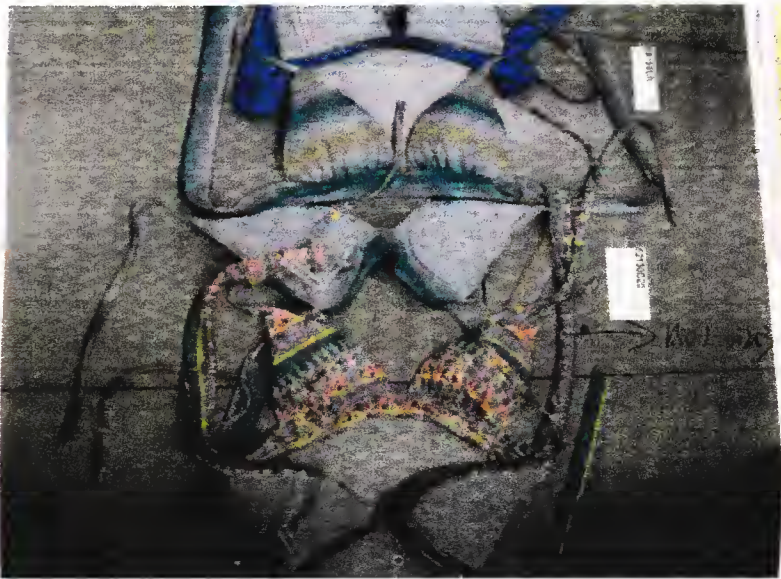
標準概述:	關於訂購牛油紙
STANDARD BRIEF:	Something about ordering butter paper
執行日期:	2015年6月1日
EXCUTION DATE:	1-Jun-15
跟進人員:	紙樣組長
FOLLOW-UP STAFFS:	Paper pattern leader
標準說明STANDARD EXPLANATION:	
<p>有絲帶交叉的部位,在紙樣上打凸&凹刀口都對不准絲帶的擺位,板房做板都是用紙樣復印的去訂絲帶,但需紙樣通知跟單訂購牛油紙,并更新板單增加牛油紙物料號 , 紙樣上也要增加牛油紙型號因為工廠需要打嚙架紙去裁.(例如:087-Q-00096)</p> <p>For where has crossing ribbons, it is hard to match the position of ribbons with protruding notch & concave notch on paper pattern. For sample room, the way to make pattern is to copy paper pattern and then take it to order ribbons. But, it is necessary for paper pattern to inform documentary tracker to order butter paper and increase material number of butter paper to update sample order. Also, number of butter paper should be written on paper pattern because factory needs print out to cut</p>	
備注說明Remarks:	

標準概述:	捆條分方向
STANDARD BRIEF:	Distinguish binding direction
執行日期:	2014年7月3日
EXCUTION DATE:	3-Jul-14
跟進人員:	紙樣組長/紙樣技術員
FOLLOW-UP STAFFS:	Paper pattern leader/Technician

標準說明STANDARD EXPLANATION:

印花款頸帶及後比帶是出捆條的,且頸帶及後比帶印花需分方向的,統一在尺寸表上備注出方向

Printing neck strap and back wing strap are made into binding. The printing of neck strap and back wing strap need to distinguish the direction. Uniformly note that they need to distinguish the direction in size spec.



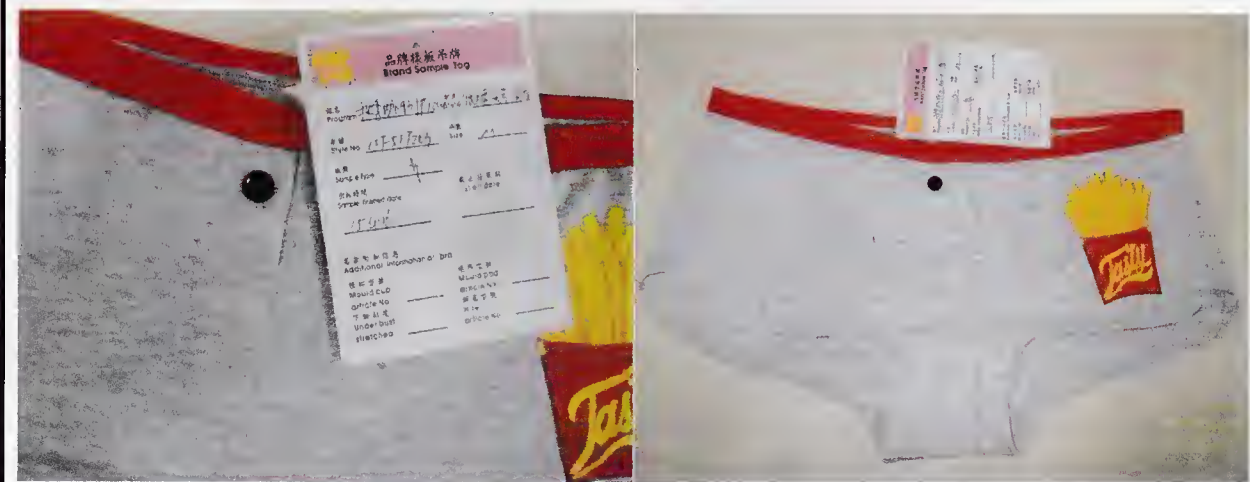
備注說明Remarks:

標準概述:	前中鈕牌的車法
STANDARD BRIEF:	Sewing method of CF fly
執行日期:	2015年4月28日
EXCUTION DATE:	28-Apr-15
跟進人員:	紙樣組長/車間
FOLLOW-UP STAFFS:	Paper pattern/ Sewing room

標準說明STANDARD EXPLANATION:

前中鈕牌用雙針車裝飾線.板房用單針車代替雙針車作板,車線間距不標準導致寫工藝時不知道用什麼針位.討論統一板房做板用正確的車種及針位做板.(參考C8F5PT263款)

Ornamental thread is sewed on fly by using t/n l/s. While making pattern, sample room use s/n l/s to substitute t/n l/s to sew. The atypia of distance between threads will cause confusion that which stitch should be used while writing craftwork. Uniformly discuss that sample room should use proper way to sew and proper stitch to make pattern.(Take C8F5PT263 for example.)



備注說明Remarks:

統一板車間用正確的針位衣車做板.
Unify that workshop should use proper stitch to make pattern.

標準概述: STANDARD BRIEF:	多層嘜頭做法
執行日期: EXCUTION DATE:	2015年4月28日 28-Apr-15
跟進人員: FOLLOW-UP STAFFS:	紙樣組長/車間 Paper pattern/ Sewing room
<p>標準說明STANDARD EXPLANATION:</p> <p>008-P-00039款此款嘜頭有11層，後V丈根也交叉重疊在後中，導致此位非常厚丈根重疊也不齊，車縫難度大，建議類似情況更改麥頭做法。</p> <p>The label of 008-P-00039 has 11 layers. elastic of back V cross at the back, which causes this part is very heavy, and overlapping elastic is not neat. So, it will be more difficult to sew. Suggesting that change the way of label when the similar situation happens.</p> <div data-bbox="138 1002 1219 1557" data-label="Image"> </div>	
<p>備注說明Remarks:</p> <p>(1)麥頭位翻單時更改做法給客人批。 Update sewing method of label to guest for approval for repeat sample order.</p> <p>(2)杯底連後背骨由疊車更改為三線鉸骨。 Cup bottom and back seam are changed to 3th o/l by overlapping and sewing.</p> <p>(3)板房以後在做板時需特別留意此問題。 Sample room should pay more attention to this problem in the future while making pattern.</p>	



合隆技術標準指引

HopLun Technical standard direction

標準概述:	嚙頭在側骨位的做法
STANDARD BRIEF:	Sewing method of label at side seam
執行日期:	2013年10月22日
EXCUTION DATE:	22-Oct-13
跟進人員:	辦房車間
FOLLOW-UP STAFFS:	Product line in sample room
標準說明STANDARD EXPLANATION:	
<p>嚙頭定在側骨位置的,側骨高度小,且先鋸側骨落嚙頭,再拉褲頭,褲比丈根的,完成易車住嚙頭,日后板房車間做板做類式款式時,建議跟單更改嚙位置.(為方便大貨生產建議跟單必須更改).</p> <p>The height of side seam is short where label is fixed. And first neaten side seam, fix label and stretch waist. It is easy to sew label after finishing. In the future, suggest that merchandiser should change the position of label when the workshop of sample room making patern or making other similar styles. (Suggest that merchandiser must change it, which is convenient for stock production.)</p> <div></div>	
備注說明Remarks:	

標準概述:	物料不同對工藝的影響
STANDARD BRIEF:	Technology effect from different materials
執行日期:	2014年8月16日
EXCUTION DATE:	16-Aug-14
跟進人員:	紙樣組長/技術技術員
FOLLOW-UP STAFFS:	Paper pattern leader/ Technician
<p>標準說明STANDARD EXPLANATION:</p> <p>板料與貨前板大料不同,影響工藝針位及止口的,板車間需通知工藝組提前更改工藝及通知工廠 (445-L-00962)</p> <p>Material of pattern differs from material of PP sample, which will influence stitch and seam allowance. It is necessary for workshop of sample room to inform craftwork group and factory to modify in advance. (445-L-00962).</p> <div data-bbox="97 1072 679 1521" data-label="Image">  </div> <div data-bbox="686 1063 1315 1550" data-label="Image">  </div>	
備注說明Remarks:	



合隆技術標準指引

HopLun Technical standard direction

標準概述:	包邊款丈根與捆條物料要配色
Standard summarise :	Elastic match colors with binding for wrapping styles
執行日期:	2018年9月26日
Term of expiration date:	26-Sep-18
跟進人員:	跟單組/紙樣組/辦房車間/工藝組
Follow-up staffs:	Merchandising/Pattern/Workshop/Technology
標準說明:	
Standard explanation :	

見下圖包下腳捆捆條是黑色,裡面的丈根是白色,完成封接駁口的時候容易露裡面丈根白色. 此種做法應該丈根與捆條要配色才對,否則是改善不了露白現象的.(注:辦車間做辦時如遇辦單開料沒有配色要通知跟單改為配色,其它環節同事也請留意,如發現此問題請反饋給相應跟單.)

Below picture shows that underbust binding is black, but the elastic inside is white, it will exposure white elastic after joining. Elastic should match colors with binding. Sample room should inform merchandiser to change to match if no match information on sample order. Other colleagues also pay attention to this kind of case.




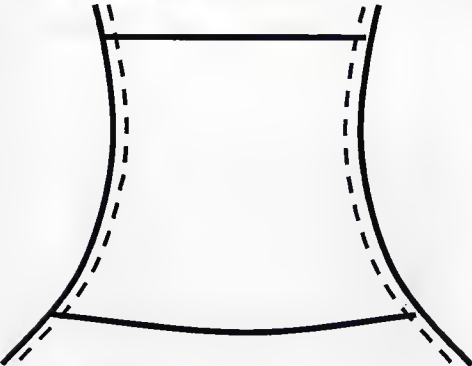
備注說明 Remarks:

標準概述:	鈕扣孔的要求
Standard summarise :	Requirement of button hole
執行日期:	2018年7月4日
Term of expiration date:	4-Jul-18
跟進人員:	跟單組 / 見客技術員 / 辦房車間 / 大貨技術員
Follow-up staffs:	Merchandising/Technician/Workshop
標準說明:	
Standard explanation :	<p>見下圖鈕釦,因訂扣子的衣車針杆大小問題,所以開發鈕釦時要注意鈕扣孔不可小於1.5MM. Pay attention to the button hole not less than 1.5MM according needle bar size.See below sketch</p> <div data-bbox="61 931 1306 1765" data-label="Image">  </div>
備注說明 Remarks:	



5、工藝做法類 Process Standard

5-1、車法類 Sewing standard

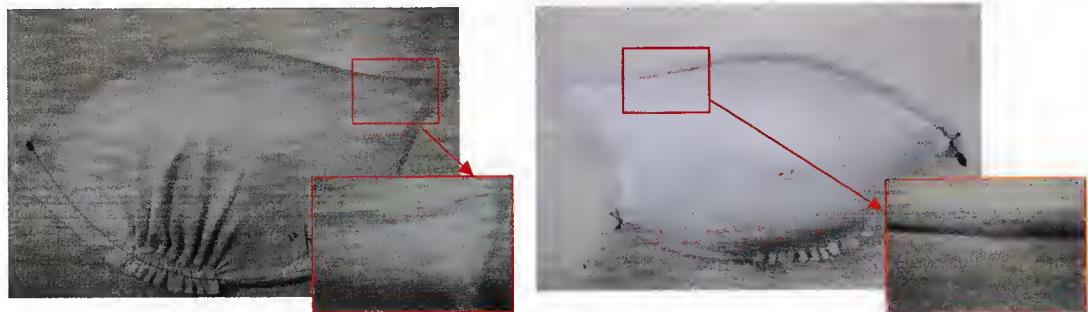
標準概述:	折腳的短袂款式單針走浪線的車法
STANDARD BRIEF:	The Ways Of S/N Sew Gusset For Fold Shorts
執行日期:	2011年6月20日
EXCUTION DATE:	20-Jun-11
跟進人員:	車間總指導/用量組/工藝員
FOLLOW-UP STAFFS:	Sewing Team Leader/ MU/ Craft
標準說明STANDARD EXPLANATION: 以下新做法目的是可以取消成品後拉斷線工序。 The purpose of the following new method is to cancel the process of crackinging stitch manually for finished. 工序名: 单针走浪线 Processing name: operation of s/n sew gusset 面線: 滌棉線(即針線)+底線: 尼龍線(即絲線) Shell thread:cotton thread(needle thread)+bottom thread: nylon thread(silk thread)	
1.款式圖例 Picture of style: 	
2.車縫分解圖resolution graph of sewing:  <div style="display: flex; justify-content: space-between; align-items: flex-start; margin-top: 10px;"> <div style="text-align: center;"> <p>--- 面線: 滌棉線(即針線) shell thread:cotton thread(needle thread)</p> <p>--- 底線: 尼龍線(即絲線) bottom thread: nylon thread(silk thread)</p> </div> <div style="text-align: center;"> <p>└-----┘ 針數要求 3cm/14針 Request of needle quantity</p> </div> </div>	
備注說明Remarks:	

標準概述:	杯邊/夾彎位運返面不見線的車法
STANDARD BRIEF:	Sewing Ways Of Baste Wrong Side Of Neckline/Armhole With Threads Be Invisible At Top
執行日期:	2011年6月20日
EXCUTION DATE:	20-Jun-11
跟進人員:	車間總指導/工藝員/核算員
FOLLOW-UP STAFFS:	Sewing Team Leader / Craft / MU

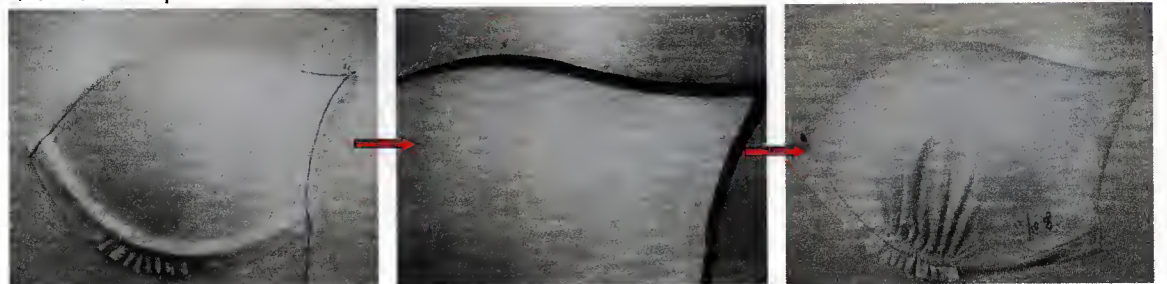
標準說明STANDARD EXPLANATION:

圓款的杯邊和夾彎位是運反面不見線時，統一為不分深淺色，均需要在杯邊和夾彎位鉸骨，取消單針襷棉杯邊1mm線。
Regardless of uneven color when baste wrong side of neckline and armhole with threads be invisible at top and it's need to overlock at neckline&armhole and cancel s/n topstitch 1mm thread into cup edge.

1. 款式圖例: 杯邊和夾彎面不見線車法 example of style: sewing ways of neckline and armhole with threads be invisible at shell



2. 車縫的工序operation of sew.



1. 單針埋杯邊和夾彎

S/n join neckline&armhole

2. 鉸骨鎖杯邊和夾彎

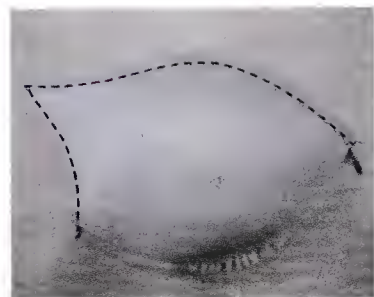
o/l lock neckline&armhole

3. 單針笠棉

s/n baste cup shell on foam cup

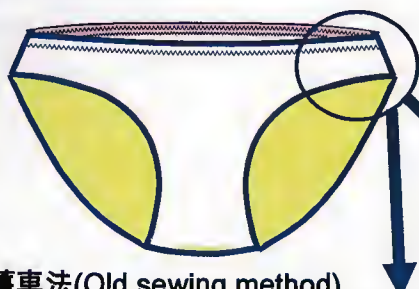
3. 取消之前的單針壓杯邊1mm線工序.

.Cancel the former operation of s/n topstitch 1mm thread into cup edge.



備註說明Remarks:

客人有特殊要求除外.Except the special request of guest

標準概述:	褲頭or褲比一圈落丈巾的駁口車法
STANDARD BRIEF:	How To Make Joint When Attach Elastic One Circle At Waistband Or Leg Opening
執行日期:	2011年1月21日
EXCUTION DATE:	21-Jan-11
跟進人員:	車間總指/技術員
FOLLOW-UP STAFFS:	Sewing Team Leader / Technician
標準說明STANDARD EXPLANATION: 褲頭/褲比一圈落丈根的款式,丈根駁口位建議面見線打棗. The style of one circle elastic attached at leg opening or waist,we suggest bartacking visibly at the joint of elastic.	
<div style="display: flex; justify-content: space-around; align-items: center;">  </div> <div style="display: flex; justify-content: space-between;"> <div style="width: 45%;"> <p>舊車法(Old sewing method)</p> <ol style="list-style-type: none"> 1.人字車落橡根 1.Zz l/s attach the elastic 2.人字車駁橡根口 2.Zz l/s join the elastic's joint 3.人字車复橡根 3.Zz l/s sew the elastic again </div> <div style="width: 45%;"> <p>新車法(New sewing method)</p> <ol style="list-style-type: none"> 1.人字車落橡根 1.Zz l/s attach the elastic 2.人字車复襟橡根 2.Zz l/s topstitch the elastic again 3.打棗車鎖橡根駁口(面見線) 3. Bt lock the elastic's joint visibly </div> </div>	
備注說明Remarks: 客人特別要求的除外. Except the especial request of customer.	

標準概述: STANDARD BRIEF:	無需密積的摺條荷葉邊車法 How To Sew Frill Without O/I Neatened Densely
執行日期: EXCUTION DATE:	2011年11月3日 3-Nov-11
跟進人員: FOLLOW-UP STAFFS:	車間總指導 Sewing Line Leader
標準說明STANDARD EXPLANATION: 荷葉邊不需密級的款式, 出入口統一用手工修剪角度,不需單針摺入摺回車. .For frill edge without o/l neatened densely,we need to trim it at entry and exit and don't need to s/n l/s it by folding in and back.	
1.舉例款式圖 .Style for example: <div data-bbox="362 849 858 1148" data-label="Image">  </div> <div data-bbox="872 1136 1239 1285" data-label="Text"> <p>此荷葉做綑條, 不需要出紙樣. This frill is as binding, and don't need to make paper</p> </div>	
2. 荷葉邊不需出紙樣, 採用綑條式車縫. 完成后用人手修剪角度. .Frill don't need to make paper pattern,pls just sew it as binding,trim it manually after finished. <div data-bbox="455 1479 939 1866" data-label="Image">  </div>	
備注說明Remarks:	

合隆技術標準指引

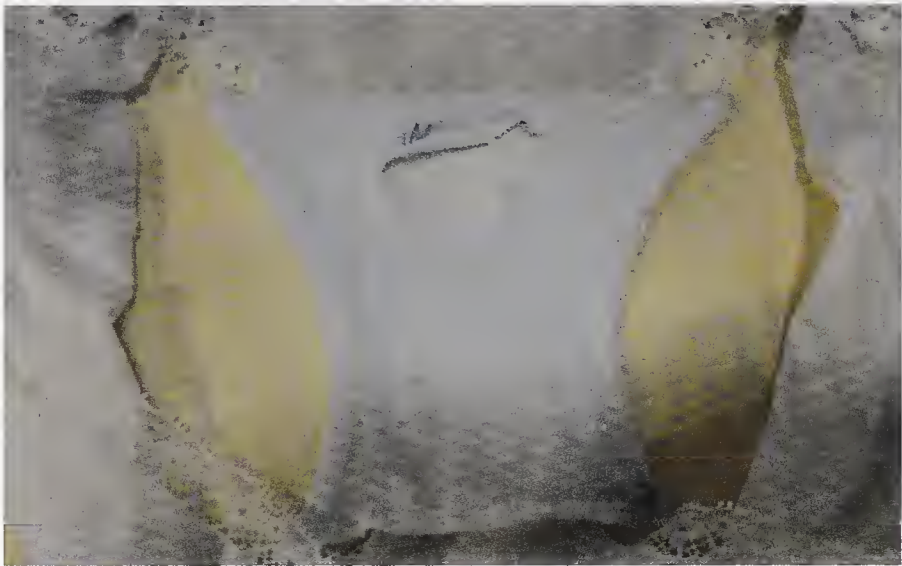
HopLun Technical standard direction

標準概述:	包後浪及浪兩邊是隱形款式的做法
STANDARD BRIEF:	The method of wrap back gusset and hidden gusset edges
執行日期:	2015年6月1日
EXCUTION DATE:	1-Jun-15
跟進人員:	車間
FOLLOW-UP STAFFS:	Production line in sample room

標準說明STANDARD EXPLANATION:

針對包後浪及浪兩邊是隱形的款式,現在浪兩邊的級骨線,有的用單針釘,有的又沒有用單針釘,請問是否可以統一做法,因為單針釘了的翻浪就快,沒有釘的翻浪很慢(458-M-00156)

For style of wrapping back gusset and hiddening gusset edges, some o/l thread of both sides of gusset are used s/n l/s to tack, but some of them are not used s/n l/s. Ask whether the method can be unified because it will be quick to turn out gusset by using s/n l/s, otherwise, it will be slow to turn out gusset without using s/n l/s.



備注說明Remarks:



合隆技術標準指引

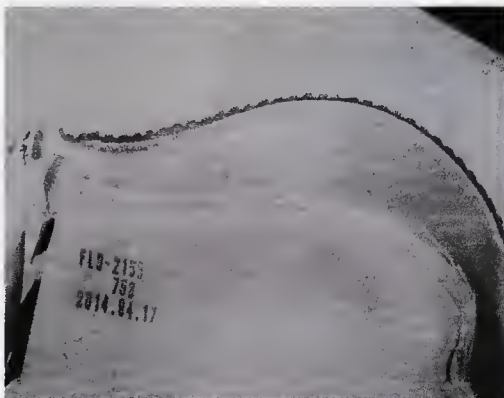
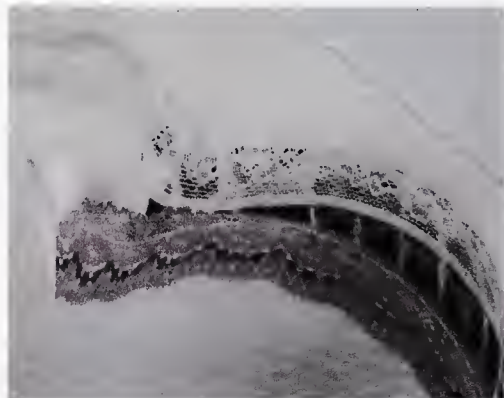
HopLun Technical standard direction

標準概述:	杯邊吊落花邊,夾彎為運反款式的車法
STANDARD BRIEF:	The sewing method of hand and attach lace at neckline while sewn-and-turn at armhole
執行日期:	2014年8月16日
EXCUTION DATE:	16-Aug-14
跟進人員:	紙樣組長/技術技術員
FOLLOW-UP STAFFS:	Paper pattern leader/ Technician

標準說明STANDARD EXPLANATION:

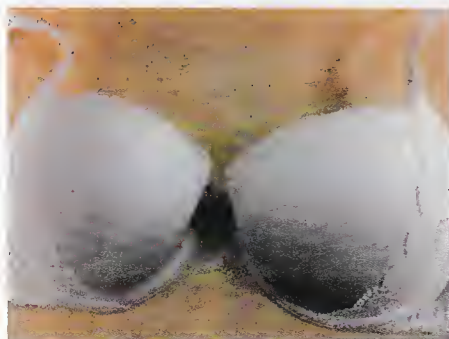
1、杯邊吊落花邊,夾彎為運反款式,工廠建議杯邊面布與棉分開,棉及骨,面布不及骨與花邊一起車在棉上,因為需先運反夾彎,再車杯邊,耳仔彎位面布易扭及花邊易起拱.((例SC14-1599)

1. For style that lace is hang and attached at cup edge and underarm is bagged out, factory suggests that the shell fabric at cup edge should be separated from foam, foam and seam, shell fabric & seam & lace are not allowed to sew on the foam. Because it needs bag out at underarm and then to sew cup edge. Shell fabrid of loop curve is easy to twist and lace is easy to arch camber. (For example, SC14-1599).



2、杯邊吊落花邊,夾彎為運反款式,花邊寬度是1.5CM,包括1.5CM,杯邊棉和面布分開車,不及到一起 (2014/11/25Update)

Cup edge hangs & attaches lace, and underarm is bagged out. Lace width is 1.5CM, including 1.5CM. Foam at cup edge and shell fabric are separated to sew rather than



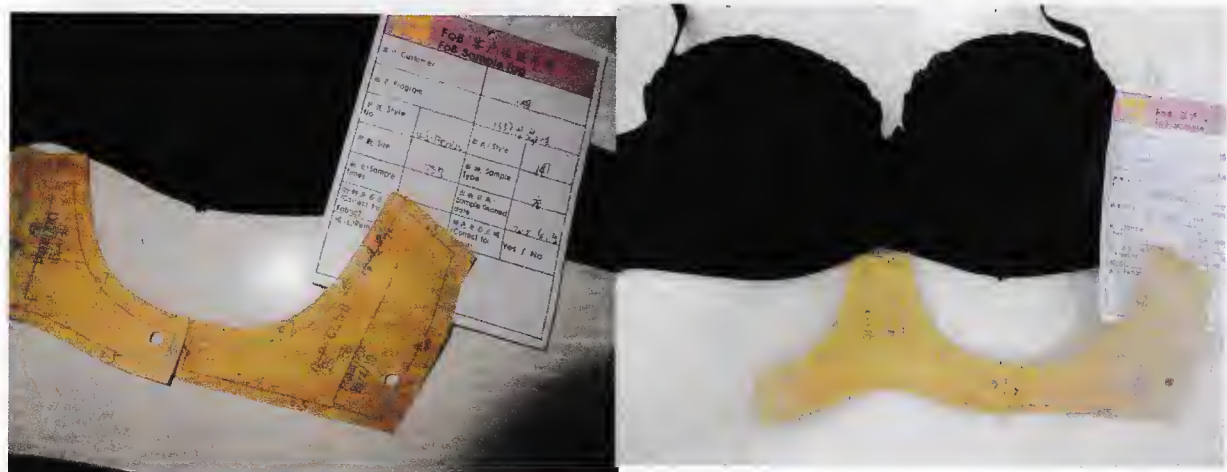
備注說明Remarks:

標準概述:	杯邊有縮皺且需拉襟丈巾的車法
STANDARD BRIEF:	The sewing method of the styles with shrinkage neckline
執行日期:	2014年7月3日
EXCUTION DATE:	3-Jul-14
跟進人員:	板房車間
FOLLOW-UP STAFFS:	Production line in sample room
<p>標準說明STANDARD EXPLANATION:</p> <p>杯邊有縮皺且需拉襟丈巾的,建議吊落縱紋定型紗,板房現有的做法是疊車,疊車不方便行貨,影響大貨效率</p> <p>Neckline is shrinking, and needs to attach&topstitch elastic. Suggests that hang & attach fixed net with bias wise, the present method of sample room is overlap. But overlap is so inconvenient for bulk that it will influence the efficiency of bulk production.</p>	
	
備注說明Remarks:	

標準概述:	長下扒順細碗款式的車法
STANDARD BRIEF:	The method of long cradle with seam allowance of upper cup towards underbust
執行日期:	2015年4月28日
EXCUTION DATE:	28-Apr-15
跟進人員:	紙樣組長/車間
FOLLOW-UP STAFFS:	Paper pattern/ Sewing room

標準說明STANDARD EXPLANATION:

長下扒順細碗款式.討論統一上碗子口7MM的雙針外線細碗是否墜針車.(參考008-P-00125款)




備注說明Remarks:

統一長下扒順細碗款式紙樣寫8MM子口的細碗不墜針車,寫7MM子口的細碗墜針車,如遇紙樣与板不符的退板給板車間返工,查驗組需監控.

合隆技術標準指引

HopLun Technical standard direction

標準概述:	車勾扣注意事項
STANDARD BRIEF:	Note of sewing Hook&eye
執行日期:	2014年3月20日
EXCUTION DATE:	20-Mar-14
跟進人員:	辦房車間
FOLLOW-UP STAFFS:	Production line in sample room
<p>標準說明STANDARD EXPLANATION:</p> <p>勾扣需打開車的,在做板時發現是粘在一起的,需同跟單反映訂大貨訂料時不要粘在一起,以便工廠生產.</p> <p>Hook and eye need to be sewed openly, but we find that they are stucked while making pattern, that is what we should reflect to the merchandiser. Also, it is convenient for factory to produce.</p> 	
備注說明Remarks:	

標準概述:	單針摺車下杯杯骨位及杯底摺的做法
STANDARD BRIEF:	Method of s/n fold&sew bottom cup seam and dart
執行日期:	2015年3月26日
EXCUTION DATE:	26-Mar-15
跟進人員:	紙樣組長/車間
FOLLOW-UP STAFFS:	Paper pattern/ Sewing room

標準說明STANDARD EXPLANATION:

單針摺車下杯杯骨位及杯底摺.原做法於剪口對折位定線,現工廠提出新做法於剪口對折,對正剪口於底先豎車線,車線長与完成止口一至,再摺回杯折貼,於杯邊及碗碗底橫車線.,完成外關及分鐘不變.建議板房做板時也按此方法做板。(087-I-00101款型格百褶組)

Use s/n l/s to fold and sew cup seam of lower cup, the original method is that fix thread at notch fold position, but at present, factory brings up the new method of notch folding. follow notch to sew at bottom, the length of thread should be consistent with the finished seam allowance, and fold back to cup. After that, to sew cup edge and cup bottom.Appearance and SMV can not be changed. Suggest that paper pattern makers should make pattern according to this method. (087-I-00101)



備注說明Remarks:

板車間板時有相同款式可推行按新做法做,於剪口對折,對正剪口於底先豎車線,車線長与完成子口一至,再摺回杯折貼,於杯邊及碗碗底橫車線.

The new method can be carried out if workshop of sample room has the similar style. Fold the notch, follow notch to sew at bottom , the length of thread should be consistent with the finished seam allowance, and fold back to cup. After that, to sew cup edge and cup bottom.



合隆技術標準指引

HopLun Technical standard direction

標準概述:	調整大碼針高
STANDARD BRIEF:	Adjust needle height for large size
執行日期:	2015年3月26日
EXCUTION DATE:	26-Mar-15
跟進人員:	紙樣組長/車間
FOLLOW-UP STAFFS:	Paper pattern/ Sewing room
標準說明STANDARD EXPLANATION:	
<p>MM客.丈根是14MM闊的,三針人字拉丈巾,客最新要求針高用10MM的高度 (原三針人字車調到最高針位是8MM) 。討論其它客是否調整大碼針高</p> <p>For MM brand. Elastic width is 14MM, and attach elastic with 3 zz. The latest requirement of customer is that the needle height should be 10MM.(The original 3 zz needle height is 8MM.)</p> <p>Discuss other customers whether the needle height of large size should be adjusted.</p>	
備注說明Remarks:	
<p>MM客要求丈根是14MM及以上的,三針人字拉丈用10MM的高度,三針人字距下腳布邊2MM.從新單開始.其它客如有要求請按流程上MEMO通知</p>	

標準概述:	鋼圈圍的車法
STANDARD BRIEF:	The sewing method of wire bra
執行日期:	2014年8月16日
EXCUTION DATE:	16-Aug-14
跟進人員:	紙樣組長/技術技術員
FOLLOW-UP STAFFS:	Paper pattern leader/ Technician
標準說明STANDARD EXPLANATION: 鋼圈圍款如客人無特別要求的,下杯骨兩層布與紗車死,單針襟線底不見線,因分開夾碗多工序且底/面杯骨易錯骨.(OK款MMS15P0195,不OK款MMS15P0756) For style with wire casing, the 2 layers of fabric of lower cup seam need to sew tightly. S/n l/s topstitch under thread where can not see the thread, because it has many processes to split join cup, and it is easy to missing seam for lining cup/ shell cup. (The OK is MMS15P0195, and not OK is MMS15P0756).	
	
備注說明Remarks:	

標準概述:	關於疊碗,捆碗面捆條款式的做法
STANDARD BRIEF:	Method of overlap cup and binding of wire casing
執行日期:	2015年6月1日
EXCUTION DATE:	1-Jun-15
跟進人員:	車間
FOLLOW-UP STAFFS:	Production line in sample room
<p>標準說明STANDARD EXPLANATION:</p> <p>關於疊碗,捆碗面捆條的款式,板房車間鄭珍建議此類款式碗圈不加及骨,特殊面料除外.如339-P-00082款.(工廠已在6月月會上同意)</p> <p>About style with overlapped cup and binding of wire casing, Kuang Zhen in workshop of sample room suggests that the wire casing of this style should not be added o/l, except for special fabric . For example, 339-P-00082. (In June, factory has already agreed at monthly meeting.)</p> <div data-bbox="278 1079 1061 1528">  </div>	
備注說明Remarks:	

標準概述:	夾彎吊紗連留長夾彎頂定型紗的做法
STANDARD BRIEF:	The method of hand&attach fixed net at armhole through armhole top
執行日期:	2013年10月22日
EXCUTION DATE:	22-Oct-13
跟進人員:	紙樣組長/紙樣技術員/辦房車間
FOLLOW-UP STAFFS:	Paper pattern leader/Technician/Product line in sample room
標準說明STANDARD EXPLANATION:	
<p>夾彎吊紗連留長夾彎頂定型紗款式,統一用筒吊落(完成定型紗從頭到尾都要有單針線).板車間做板時也按此方法做貨.</p> <p>For style that handing & attaching fixed net at armhole through armhole top, uniformly use folder to hang & attach.(From beginning to end, fixed net should have s/n basting.) The workshop of sample room should produce accoding to this method when they are making pattern.</p>	
	
備注說明Remarks:	

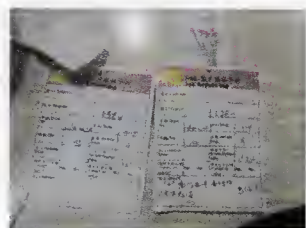
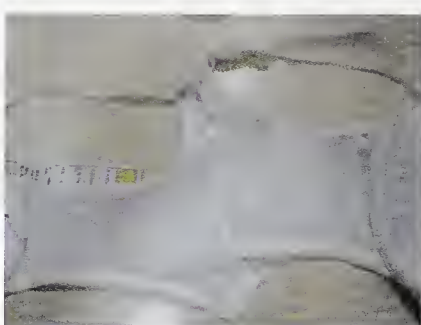
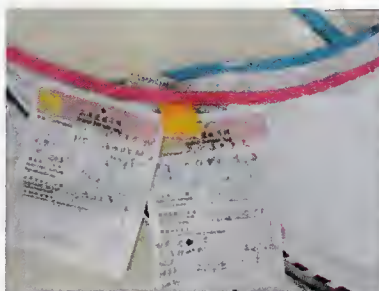
合隆技術標準指引

HopLun Technical standard direction

標準概述:	開貨板同組單大小碼做法需統一
STANDARD BRIEF:	The method of small& large size in the same program should be the same for production sample
執行日期:	2015年3月26日
EXCUTION DATE:	26-Mar-15
跟進人員:	紙樣組長/車間
FOLLOW-UP STAFFS:	Paper pattern/ Sewing room

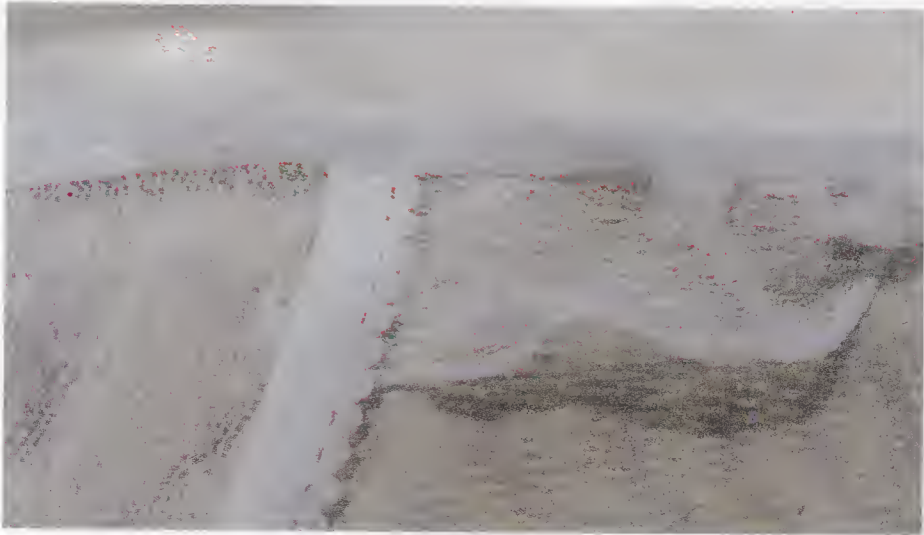
標準說明STANDARD EXPLANATION:

開貨板同組單大小碼做法不統一款，為方便大貨生產再次提出同組單大小碼需統一做法
 (案例：包背圍組018-N-00055/55A款。夏季泳衣系列12組C8S5SW048A/B款)
 For style that size S and L in the same program are different from production sample, bring it up once again that the method of size S and L in the same program should be consistent, which is convenient for stock production.(Case: 018-N-00055/55A; The series of swimwear NO.12 C8S5SW048A/B.



備注說明Remarks:

做板時同組單需統一做法.還有待部門經理進一步溝通.
 Unify the method in same program when making pattern. Also, it needs to futher communicate with department manager.

標準概述:	褲子荷葉邊的做法
STANDARD BRIEF:	Sewing method of frill for bottom
執行日期:	2013年10月22日
EXCUTION DATE:	22-Oct-13
跟進人員:	紙樣組長/紙樣技術員/辦房車間
FOLLOW-UP STAFFS:	Paper pattern/Technician/Product line in sample room
<p>標準說明STANDARD EXPLANATION:</p> <p>褲頭,前幅或后幅連兩側有荷葉款.統一做法:先人字拉/襟褲比后,再人字落腰頭荷葉褶連留長兩側荷葉褶.后再人字疊車荷花葉邊于前或后褲比位(如遇荷葉布邊散絲就需加級骨)然後再做腰頭工序方便大貨生產</p> <div data-bbox="191 1212 1106 1747" data-label="Image">  </div>	
備注說明Remarks:	

標準概述:	捆條邊落丈巾的做法
STANDARD BRIEF:	The method of attaching elastic at the edge of binding
執行日期:	2014年8月16日
EXCUTION DATE:	16-Aug-14
跟進人員:	紙樣組長/技術技術員
FOLLOW-UP STAFFS:	Paper pattern leader/ Technician
<p>標準說明STANDARD EXPLANATION:</p> <p>有關捆條邊落丈巾面坎雙針的做法。</p> <p>About the method of attaching elastic at the edge of binding and t/n l/s at shell</p> <div data-bbox="111 1106 1112 1793" data-label="Image">  </div>	
<p>備注說明Remarks:</p>	



合隆技術標準指引

HopLun Technical standard direction

標準概述:

遵循捆條縮摺縮率

STANDARD BRIEF:

Follow shrinkage ratio of binding

執行日期:

2013年11月19日

EXCUTION DATE:

19-Nov-13

跟進人員:

辦房車間

FOLLOW-UP STAFFS:

production line in sample room

標準說明STANDARD EXPLANATION:

捆條需縮折的,車間一定要跟足紙樣師傅給的縮率做板,避免樣板跟大貨外觀不同(縮率不同).

When binding need shrinkage, sewing room must follow the shrinkage ratio offered by paper pattern to avoid the appearance difference between sample and bulk product.(different shrinkage)



備注說明Remarks:

標準概述: STANDARD BRIEF:	落荷葉邊及需包邊款式的車法 edge
執行日期: EXCUTION DATE:	2014年7月3日 3-Jul-14
跟進人員: FOLLOW-UP STAFFS:	板房車間 Production line in sample room
標準說明STANDARD EXPLANATION: 杯邊,褲頭及褲比位有落荷葉邊及需包邊的款式,盡量都用級骨落捆條,板房現有的很多款式都沒有調級骨車落捆條:因用量組是按板計算用量,工藝統一按板寫工藝 For style with attaching frill and wrapping edge at cup edge, waist and leg opening, try to use attach binding by o/l. But there are many styles doesn't attach binding by o/l, because dosage group calculates usage according to pattern, and technology group uniformly write artwork according to pattern.	
	
備注說明Remarks:	



合隆技術標準指引

HopLun Technical standard direction

標準概述:	人字和三針拉褲頭褲比丈根一整圈款式的丈根駁口位
STANDARD BRIEF:	Elastic joint for the styles using zz and 3zz to attach elastic at waist and legopening
執行日期:	2013年3月13日
EXCUTION DATE:	13-Mar-13
跟進人員:	辦房車間
FOLLOW-UP STAFFS:	product line in sample room
標準說明STANDARD EXPLANATION:	
<p>對於人字和三針拉褲頭褲比丈根一整圈的款式,板房各班組的丈根駁口現統一為:</p> <p>用三針車做貨的丈根駁口在穿起計的左邊;</p> <p>用人字車做貨的丈根駁口在穿起計的右邊.</p> <p>Regarding those styles that using zz or 3/zz to attach elastic to full waist/leg opening,now unify to join elastic end,if use 3/zz, pls join elastic end at left side as worn,but if use zz,pls join elastic end at right side as worn</p> <div></div>	
備注說明Remarks:	

標準概述:	改開貨辦做法的注意事項
STANDARD BRIEF:	Note of revising PP sample
執行日期:	2014年7月3日
EXCUTION DATE:	3-Jul-14
跟進人員:	板房車間
FOLLOW-UP STAFFS:	Production line in sample room
<p>標準說明STANDARD EXPLANATION:</p> <p>板車間在按工藝做貨前板時,如需要改開貨板及紅扣板的做法時,需及時通知工藝組,以免大貨做法與紅扣板不符.</p> <p>When workshop of sample room making sample according to artcraftwork, if it needs to modify sample and the method of Red sample, please inform technology group in time ,which lests that the method of stock production is inconsistent with Red sample.</p> <div data-bbox="221 1161 1028 1692">  </div>	
<p>備注說明Remarks:</p>	

合隆技術標準指引

HopLun Technical standard direction

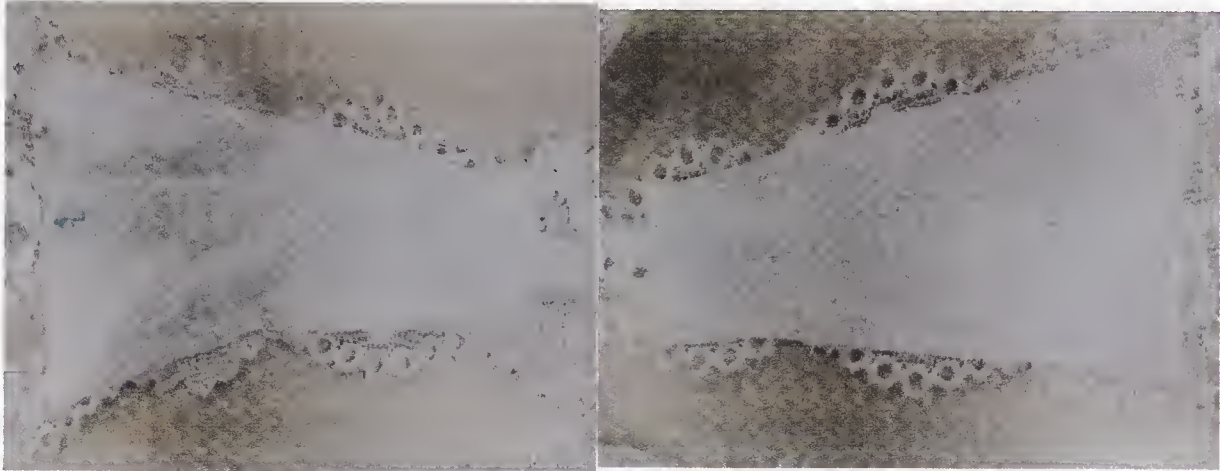
標準概述:	上比連夾用捆條+丈根人字包邊款式的做法
STANDARD BRIEF:	underarm
執行日期:	2015年3月26日
EXCUTION DATE:	26-Mar-15
跟進人員:	紙樣組長/車間
FOLLOW-UP STAFFS:	Paper pattern/ Sewing room
標準說明STANDARD EXPLANATION: <p>上比連夾用捆條+丈根人字包邊款,原做法是將丈根放在面層捆條內完成耳仔位容易外翻,現經測試將丈根放里層捆條內.完成可改善耳仔位外翻問題.建議在做板時統一按此方法做.(如同件貨有下比也要包邊,建議統一將丈根放到同一面做,并備註清楚丈根在那層)(參考339-M-00579款米高V型組)</p> <p>For style with binding+elastic on upper wing through underarm, the original method is that put elastic into binding at shell but it is easy to turn over. But now, after testing, put elastic into inner layer, which can improve the problem. Suggest that uniformly making pattern according to this method. (For example, if there is the same good with lower wing , the lower wings also need to wrap edge, uniformly suggest that put elastic in the same layer, and clearly note that elastic in that layer.) (Take 339-M-00579, micro V).</p>	
	
備注說明Remarks: <p>捆條+丈根人字包邊款.如遇耳仔位完成容易外翻.板房車間做板時(看款式而定)將丈根放里層捆條內做.同件貨下比也需人字包邊的.上下比做一樣將丈根放里層捆條內做.</p> <p>For style with binding and elastic wrapping edge, if workers in sewing room find that the looping is easy to turn over, they should put elastic into binding at inner layer(It depends on styles.)The lower wings in the same good also need to zz l/s wrap edge. The method of upper and lower wing are same: put elastic into binding at inner layer.</p>	

標準概述:	特殊款式的车法
STANDARD BRIEF:	The method of special styles
執行日期:	2015年4月28日
EXCUTION DATE:	28-Apr-15
跟進人員:	紙樣組長/車間
FOLLOW-UP STAFFS:	Paper pattern/ Sewing room
標準說明STANDARD EXPLANATION: 087-N-00208/087-N-00206 款 Style 087-N-00208/087-N-00206 (1)前/後幅紙格花邊P點在浪骨位,側骨位遇高波折波,工廠建議側骨位保持寬度.不用折波 On paper pattern, the lace point P of front/back part is at gusset seam. High scallop will fold scallop when meeting side seam. Factory suggests that side seam should keep width. (2) 087-N-00206 款後V位開貨板是用坎車行單線襟V骨,工廠建議後V位受力不大的用單針襟線(底用尼龍線) Style 087-N-00206, back "V" of sample is to sew single thread line topstitch V-shape by c/s. Factory suggests that if the back "V" is not stressed, it can s/n topstitch. (Nylon thread is used in bottom.) (3)褲頭位丈根駁口在後V骨位處太厚,丈根重疊不齊.工廠建议類似做法更改駁口位置。 Elastic joint at back "V" is too thick, and overlapping elastic is not neat. Factory suggests that use similar method to change the place of joint.	
<div style="display: flex; justify-content: space-around;">   </div>	
備注說明Remarks: (1)沒有前後幅闊尺寸的沒有里布及花波低波小於5MM的,紙格側骨位出保持寬度.不用折波. Without front or back part width measurement & lining, and low scallop is less than 5MM, side seam on paper pattern should keep width rather than fold scallop. (2)統一後V位受力不大的用單針襟線(底用尼龍線,線路要調松,不可緊) Unify the back "V" is not stressed, it can s/n topstitch.(Nylon thread is used in bottom, stitch is loose) (3)丈根駁口統一有側骨的駁在側骨位.沒有側骨的駁在後V骨偏左處. Unify that elastic joint should be joined at side seam. Without side seam, elastic joint should be joined on the left of back "V".	



合隆技術標準指引

HopLun Technical standard direction

標準概述:	統一同組單,同款式的做法
STANDARD BRIEF:	Unification for the same program and the same style
執行日期:	2013年3月13日
EXCUTION DATE:	13-Mar-13
跟進人員:	紙樣組長/辦房車間
FOLLOW-UP STAFFS:	Paper pattern leader and product line in sample room
標準說明STANDARD EXPLANATION:	
<p>同組單,同款式的做法盡量統一,尽量用简单的车法做办.</p> <p>Unify the sewing method for the same program and same style, and try to use simple way to make sample.</p> <div></div>	
備注說明Remarks:	

標準概述:	統一泳衣九字扣開口
STANDARD BRIEF:	Unify the slider open of swimwear
執行日期:	2014年7月3日
EXCUTION DATE:	3-Jul-14
跟進人員:	板房車間
FOLLOW-UP STAFFS:	Production line in sample room

標準說明STANDARD EXPLANATION:

泳衣比尾一邊有九字扣的款式,所有客統一九字扣開口穿起計朝下

For the wing end of swimwear with the slider open, for all customers, unify that the opening of slider open is down as worn.



備注說明Remarks:



合隆技術標準指引

HopLun Technical standard direction

標準概述:	鋁骨車落丈根
STANDARD BRIEF:	O/L attach elastic
執行日期:	2015年4月28日
EXCUTION DATE:	28-Apr-15
跟進人員:	辦房車間
FOLLOW-UP STAFFS:	Product line in sample room

標準說明STANDARD EXPLANATION:

再次重提褲款褲頭褲比丈根封度為6mm,如有雪紡布,色丁布,提花布等需要鋁佈邊的款式.統一用鋁骨車落丈根.(客人特殊要求除外).(參考087-N-00207款)(註:此問題2011年1月份已經統一過)

Bring up once again that elastic width at waist and leg opening should be 6mm. For styles in chiffon, satin fabric, jacquard fabric,etc that need to o/l fabric edge. Uniformly o/l sew and attach elastic.(Except for special requirements of customers.)(Take 087-N-00207)(Note: This problem is solved in January,2011.)



備注說明Remarks:

統一褲款褲頭褲比丈根封度為6mm,雪紡布,色丁布,提花布等需要鋁佈邊的款式.統一用鋁骨車落丈根.(客人特殊要求除外)

Unify that elastic width at waist and leg opening are 6mm. For style in chiffon, satin fabric, jacquard fabric, etc that need to o/l fabric edge, uniformly o/l sew and attach elastic.(Except for special requirements of customers.



合隆技術標準指引

HopLun Technical standard direction

標準概述:	下比位是出裁片的做法
STANDARD BRIEF:	The method of cutting piece at lower wing
執行日期:	2015年3月26日
EXCUTION DATE:	26-Mar-15
跟進人員:	紙樣組長/車間
FOLLOW-UP STAFFS:	Paper pattern/ Sewing room
標準說明STANDARD EXPLANATION:	
<p>445-N-00289款後下比位是出裁片,裁片對折級骨後翻出面不見線,再內穿膠片.此款式建議出細條,做板時用坎車拉細條連落膠片連運反</p> <p>Under back wing of 445-N-00289 is required to cut pieces. After folding and o/l, thread is invisible when cutting pieces is turned out, and then wear inside rubber band.For this style, suggest to cut binding. C/s attach binding through rubber band to bag out.</p>	
	
備注說明Remarks:	
<p>類似款式統一做頭板板時用坎車拉細條連落膠片連運反.</p> <p>For similar styles, unify that c/s attach binding through rubber band to bag out when making sample.</p>	

標準概述:	下腳摺出紙格內包丈根款式的車法
STANDARD BRIEF:	The remark in size set should be reasonable
執行日期:	2015年4月28日
EXCUTION DATE:	28-Apr-15
跟進人員:	紙樣組長/車間
FOLLOW-UP STAFFS:	Paper pattern/ Sewing room
標準說明STANDARD EXPLANATION:	
<p>下腳摺出紙格內包丈根款式,建議將工序單針走下腳摺線(內放丈根)更改為凹車單支針走線.完成不用拉斷單針線.(參考070-N-00035款)</p> <p>For style that bottom trim wrap elastic inside, suggest that changing s/n l/s sew binding thread at underbust in process (put elastic in inner) into F/L s/n l/s sew. After finish, it will not break s/n basting. (Take 070-N-00035)</p>	
	
備注說明Remarks:	
<p>統一改為凹車單支針走線.完成不用拉斷單針線.</p> <p>Unify to change into F/L s/n l/s sew. It will not break s/n basting after finish.</p>	

標準概述:	牙籤骨的做法
STANDARD BRIEF:	The method of toothpick bone
執行日期:	2013年10月22日
EXCUTION DATE:	22-Oct-13
跟進人員:	紙樣組長/紙樣技術員/辦房車間
FOLLOW-UP STAFFS:	Paper pattern leader/Technician/Product line in sample room
<p>標準說明STANDARD EXPLANATION:</p> <p>牙籤折骨不是左右對稱的款,統一做順方向自然倒骨位.(車間做板時特別留意)</p> <p>For style that toothpick bone is not symmetric, seam towards naturally.(Workshop should pay more attention when making pattern.)</p> 	
備注說明Remarks:	

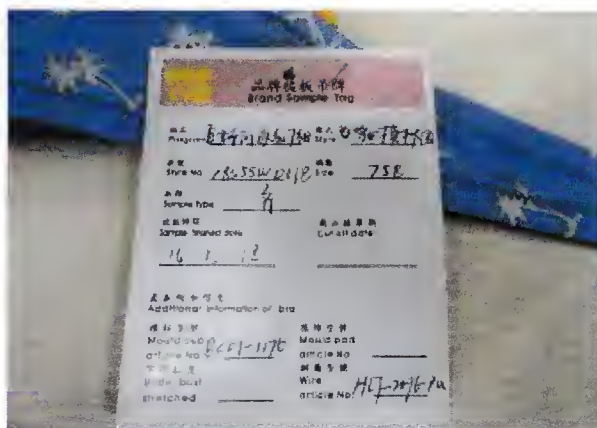
標準概述:	易散口布料的做法
STANDARD BRIEF:	The method of fabric with raw edge easily
執行日期:	2015年3月26日
EXCUTION DATE:	26-Mar-15
跟進人員:	紙樣組長/車間
FOLLOW-UP STAFFS:	Paper pattern/ Sewing room
標準說明STANDARD EXPLANATION:	
<p>074-M-00001 此款布料是网眼毛衣布料, 裁好的裁片碰到邊就會散口. 做板用單針走里布, 做好成品後還要拉單針線, 建議類似款式用人字里布線完成後不用拉斷線.</p> <p>074-M-00001, The fabric is brushed with mesh hole, so the cutting pieces will raw edge when touching the side. Use s/n l/s to sew lining fabric while making pattern. Also need to attach s/n basting after finish. Suggest that similar styles should use zz to sew lining. After finish, stitch will not be cracked.</p>	
	
備注說明Remarks:	
待測試後再討論.	
To discuss after testing.	

標準概述:	泳裝類頸帶或綁帶的做法
STANDARD BRIEF:	Method of tie for swimwear
執行日期:	2015年3月26日
EXCUTION DATE:	26-Mar-15
跟進人員:	紙樣組長/車間
FOLLOW-UP STAFFS:	Paper pattern/ Sewing room

標準說明STANDARD EXPLANATION:

如泳裝類頸帶或綁帶原板房月會統一不加燙,如特殊款需加燙的,紙樣需在備註欄上備註以便工藝增加工序.現工廠反映板房開貨板是加燙的,沒有備註加燙.如(C8S5SW001B款夏季系列泳衣7組)

The monthly meeting hold by sample room unifies swimwear with neck straps or strings not to be ironed. If there are special styles that need to be ironed, paper pattern makers should remark in remark column so as to be convenient for technology group to increase process. At present, factory reflects that sample is not ironed because there is no remark.(For example, C8S5SW001B, swimwear in summer Group 7.)



備註說明Remarks:

統一泳裝類頸帶或綁帶不加燙,板也不可以燙.如特殊款需加燙的需在備註欄上備註.(150客統一加燙)

Unify swimwear with neck straps or strings not to be ironed, so does sample. Remark in remark column if there are special styles that need to be ironed.(150 Customer requires to iron.)



合隆技術標準指引

HopLun Technical standard direction

標準概述:	針對夾彎與上比輔料不同的做法
STANDARD BRIEF:	The method of different material at armhole and upper wing
執行日期:	2015年3月26日
EXCUTION DATE:	26-Mar-15
跟進人員:	紙樣組長/車間
FOLLOW-UP STAFFS:	Paper pattern/ Sewing room
標準說明STANDARD EXPLANATION:	
<p>針對夾彎與上比輔料不同時,原做法有兩種 1 : 先人字拉襟上下比丈根後再上碗。2 : 先上碗後再拉上比丈根。為方便大貨生產 , 工廠建議板房做頭板時先拉襟好上比再上碗(參考008-L-00991款)</p> <p>For different material between underarm and upper wing, there are 2 original methods: 1. Firstly, zz l/s attach&topstitch elastic at upper and lower wing and then at front neckline. 2 : Front neckline goes first and then attaches elastic at upper wing. In order to be convenient for bulk production, factory suggests that attach&topstitch elastic at upper wing goes first and then at front neckline. (Take 008-L-00991 as reference.)</p>	
	
備注說明Remarks:	
<p>針對夾彎與上比輔料不同時,統一板車間做頭板時做先拉襟好上比再上碗給客批.(如客有特殊要求除外)</p> <p>For different material between underarm and upper wing, unify that attach&topstitch elastic at upper wing goes first and then at front neckline. (Except for special requirements of customers.)</p>	

標準概述:	裝飾扣的做法
STANDARD BRIEF:	The method of decoration
執行日期:	2013年4月24日
EXCUTION DATE:	24-Apr-13
跟進人員:	紙樣組長/辦房車間
FOLLOW-UP STAFFS:	Paper pattern leader and product line in sample room

標準說明STANDARD EXPLANATION:

如附圖前中裝飾扣太緊,非常難穿.板房日後在做板時有此类装饰扣,九扣,O/8扣等...,在做板時如反現穿扣困難的,必須及時反饋給到跟單,以便提前做相應的改善。

As the decoration in attached picture is too tight, which is difficult to wear. If there are similar decorations that are difficult to insert while making pattern, such as 9-shape hook, ring/slider, etc, it must be in time to reflect to merchandisers so as to accordingly improve in advance.



備注說明Remarks:



合隆技術標準指引

HopLun Technical standard direction

標準概述:	008客NB單COS單鎖勾圈要求
Standard summarise :	H&M requirement of locking H&E for NB&COS series
執行日期:	2016年6月1日
Term of expiration date:	1-Jun-16
跟進人員:	紙樣組/辦房車間/工藝組
Follow-up staffs:	Pattern Team/Workshop in sample room/Technology tea

標準說明:	
Standard explanation :	

008客NB單COS單鎖勾圈(見圖1),統一以下(見圖2) :

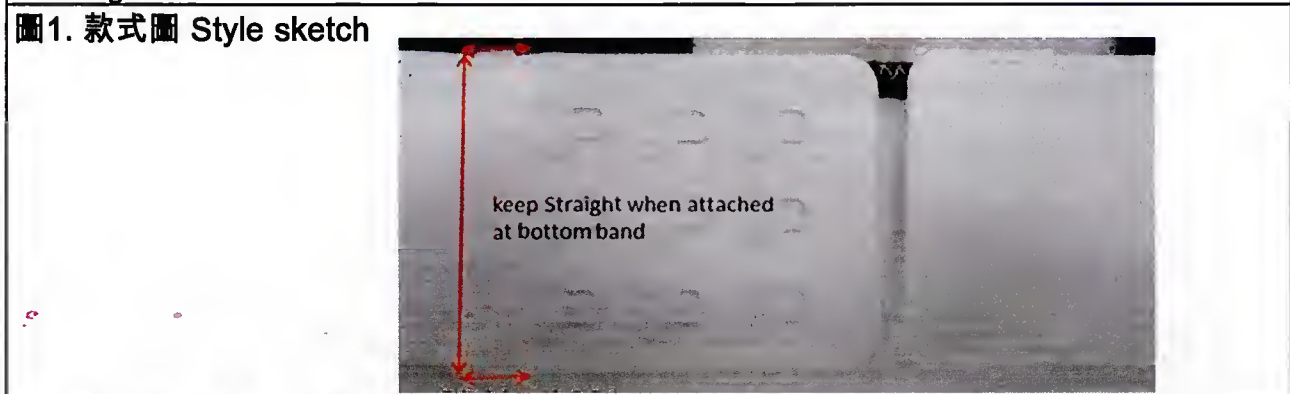
Locking H&E for NB&COS series, unify below:

COS單1:兩側車線長0.8-1CM,2:密鎖針數:14-15針/CM,3:車縫內容註明:線跡收尾不能松.

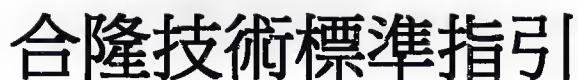
COS sries:1.stitch length is 0.8-1CM;2. 14-15 needle per CM; 3. remark that cannot loose at stitching end

NB單1:兩側車線長1CM,2:密鎖針數:14-15針/CM,3:車縫內容註明:線跡收尾不能松.

NB sries:1.stitch length is 1CM;2. 14-15 needle per CM; 3. remark that cannot loose at stitching end



備注說明 Remarks:	
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HopLun Technical standard direction

5-1-39



合隆技術標準指引

HopLun Technical standard direction

標準概述:	U型孔包網條做法
Standard summarise :	Wrap binding for U hole
執行日期:	2016年7月5日
Term of expiration date:	5-Jul-16
跟進人員:	紙樣組/辦房車間/工藝組
Follow-up staffs:	Pattern Team/Workshop in sample room/Technology tea
標準說明:	
Standard explanation :	

U型孔位置加了定型紗或在不受力位置的(見圖1),統一用單針車網條包邊.(見圖2)
Unify that wrap binding with S/N for U hole which has fixed net or unstressed

圖1. 款式圖
Style sketch

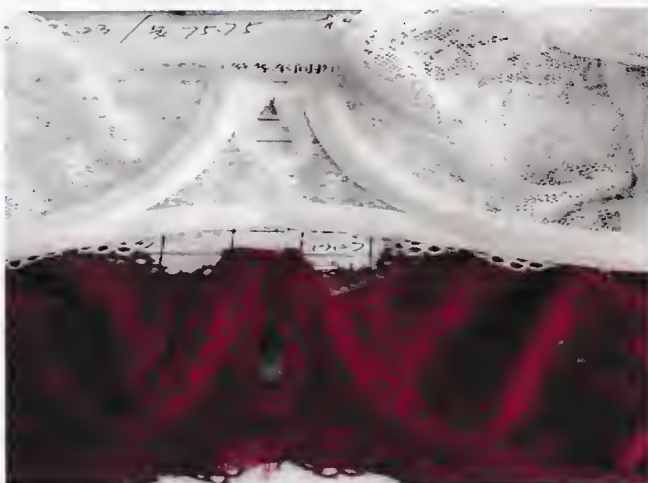


圖2. 用單針車網條包邊
Wrap binding with S/N



備注說明 Remarks:

標準概述:	杯邊工序做法統一
Standard summarise :	Method of sewing front neckline
執行日期:	2017年12月14日
Term of expiration date:	14-Dec-17
跟進人員:	跟單組/用量組/辦房車間/大貨技術員
Follow-up staffs:	Merchandising/Unit consumption/Workshop/Technician

標準說明:	
Standard explanation :	

工廠反映現在越來越多的胸圍大貨杯邊是用訂點工序,而不是平車直接車杯邊,這樣很不方便大貨生產,進度慢好多,剪綫又加重,建議做板時用平車車杯邊,既不影響外觀,也不影響試身,現在統一做板時首選用單針車杯邊給客人批板.(客人要求除外)

Factory reflect more and more tack point at front neckline instead of S/N sew front neckline, which is inconvenient for bulk. Suggest sew front neckline with S/N, does not affect the appearance, also does not affect fitting (except guest require)



備注說明 Remarks:

標準概述:	杯邊加絲線
Standard summarise :	Increase a silk thread at neckline
執行日期:	2018年5月9日
Term of expiration date:	9-May-18
跟進人員:	跟單組/用量組/辦房車間/大貨技術員
Follow-up staffs:	Merchandising/Unit consumption/Workshop/Technician
標準說明:	
Standard explanation :	<p>杯邊是運反有防水布,杯面布很薄的款,與國內工廠開會已經達成共識,工廠生產時看具體款式自行在杯邊加多一條絲線,工藝不變.板房在用量上增加多用一條絲線的用量.</p> <p>Neckline bagged out with waterproof fabric and thin shell fabric,reach an agreement with civil factories that increase a silk thread at neckline by themselves depending on style. Keep craft the same and increase silk thread consumption</p>
	
備注說明 Remarks:	

標準概述:	定織帶耳仔做法
Standard summarise :	Fix loop with woven strap
執行日期:	2016年6月29
Term of expiration date:	29-Jun-16
跟進人員:	紙樣組/辦房車間/工藝組
Follow-up staffs:	Pattern Team/Workshop in sample room/Technology tea

標準說明:

Standard explanation :

1:(見圖1)織帶料定耳仔類做法.

2:統一所有客用織帶定耳仔的做法:耳仔對折,車線在1/2處回針.再折回耳仔定線.(客人特別要求及挂膠九扣的除外)(見圖2)

For the loop with woven strap, unify that fold the loop and back stitch at 1/2 position, then fold back loop end to fix thread(except for special customer requirements and the styles of hanging 9-shape plastic slider)

圖1. 款式圖

Style sketch



圖2.做法:耳仔對折,車線在1/2處回針.再折回耳仔定線.(客人特別要求及挂膠九扣的除外)

Fold the loop and back stitch at 1/2 position, then fold back loop end to fix thread(except for special customer requirements and the styles of hanging 9-shape plastic slider)



備注說明 Remarks:

註:有客人特別要求及挂膠九扣的除外.

Except for special customer requirements and the styles of hanging 9-shape plastic slider

標準概述:	定麥頭工序標準
Standard summarise :	Standard of fixing label
執行日期:	2013年7月
Term of expiration date:	1-Jul-13
跟進人員:	紙樣組/辦房車間/工藝組
Follow-up staffs:	Pattern Team/Workshop in sample room/Technology tea
標準說明:	
Standard explanation :	
<p>定麥頭標準(見圖1),統一以下:Unify the standard of fixing label as following</p> <ol style="list-style-type: none"> 二種寬度的麥頭直接單針定在貨上。 S/N fix the label on sample directly for 2 kinds of width label 三種寬度的增加單針車麥頭的工序。 Increase s/n sew label for 3 kinds of width label 5個及5個以上的都需要有一道單針車麥頭工序。 Need s/n sew label for 5 and 5 above labels 從16年7月開始新單445客麥頭2種封度的加單獨定麥頭工序 Increase s/n sew label for 2 kinds of width label for AEO from July,2016 	
圖1. 款式圖	
圖2.	
備注說明 Remarks:	

標準概述:	花邊款骨位做法
Standard summarise :	Method of lace with seam
執行日期:	2017年9月6日
Term of expiration date:	6-Sep-17
跟進人員:	紙樣組/辦房車間/大货技术员
Follow-up staffs:	Pattern/Workshop/Technician
標準說明:	
Standard explanation :	

見下圖后背位置中間花邊骨做法,統一似款式從做見客發展板開始做襟骨給客人批板,不要做開骨,如客人要求做雙針開骨就做3/16"針位,不要做1/8"針位開骨.

Method of lace with seam as follow sketch, unify to use topsitich lace instead of sew lace seam from develop sample. For example, if guest require to T/N sew lace seam, just use 3/16" T/N, not 1/8" T/N



備注說明 Remarks:

參考案例008-AA-00164款

008-AA-00164 for reference

HopLun Technical standard direction

標準概述:	耳仔完成是三層的做法
Standard summarise :	Method of loop with 3layer after finish
執行日期:	2017年12月14日
Term of expiration date:	14-Dec-17
跟進人員:	跟單組/用量組/辦房車間/大貨技術員
Follow-up staffs:	Merchandising/Unit consumption/Workshop/Technician

標準說明:
Standard explanation :

完成耳仔是三層的做法的款,統一首選跟第一種做法定耳仔.見附頁圖效果(註:客人要求除外)

For loop with 3layer after finish, choose below method as first choice to fix loop(except guest require)



備注說明 Remarks:

標準概述:	花邊受力的部位都要加及骨
Standard summarise :	Increase OL at stressed area of lace
執行日期:	2016年6月1日
Term of expiration date:	1-Jun-16
跟進人員:	紙樣組/辦房車間/工藝組
Follow-up staffs:	Pattern Team/Workshop in sample room/Technology tea
標準說明:	
Standard explanation :	
1:(見圖1)花邊有受力的部位款式 2:統一花邊受力的部位都要加及骨.(見圖2) For the style of stress area of lace, unify that increase OL at the stressed area	
圖1. 款式圖 Style sketch	
圖2.統一花邊受力的部位都要加及骨 Increase OL at the stressed area	
備注說明 Remarks:	



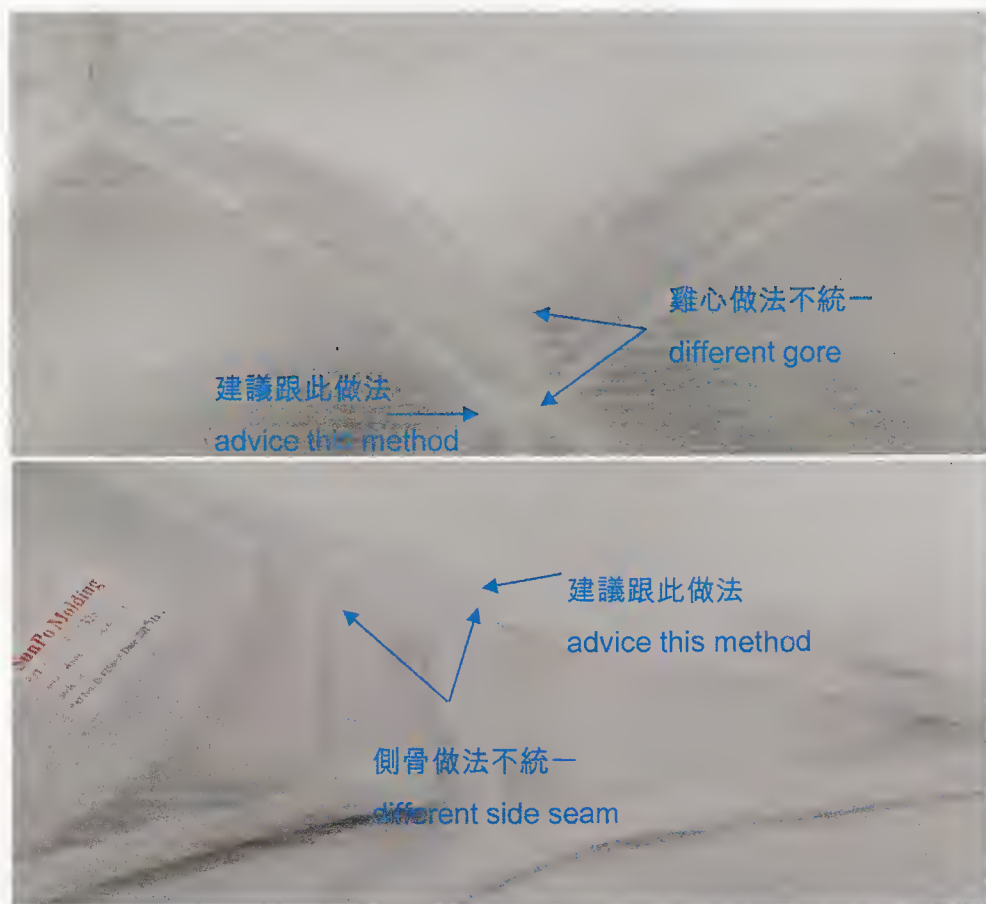
合隆技術標準指引

HopLun Technical standard direction

標準概述:	雞心位及側骨特殊做法
Standard summarise :	Special method of gore & side seam
執行日期:	2018年9月26日
Term of expiration date:	26-Sep-18
跟進人員:	紙樣組/辦房車間/工藝組/技術員
Follow-up staffs:	Pattern/Workshop/Technology/Technician
標準說明:	
Standard explanation :	

見下圖,雞心位及側骨做法不統一,車間做辦時要注意,并反饋給見客技術員与客人溝通,建議客人更改做法一致.(註:要建議是不影響外觀,更方便生產的做法.)

Method of gore and side seam are different, workshop should pay attention to the problem and feed back to technician, advice change the same after communicating with guest(no affect appearance and convient for bulk)




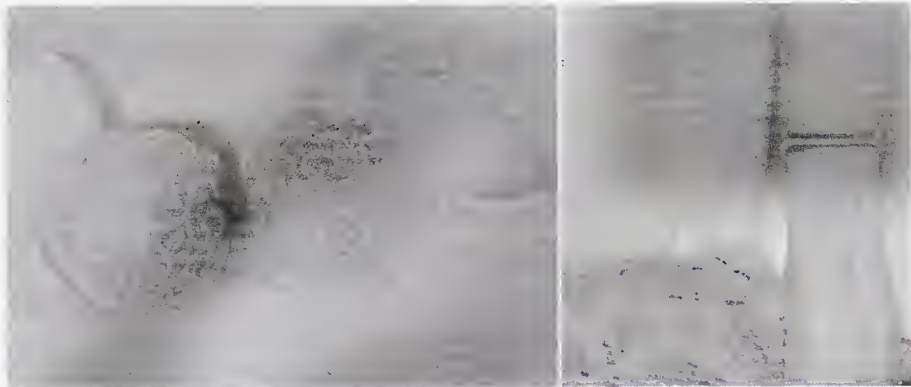

備注說明 Remarks:



合隆技術標準指引

HopLun Technical standard direction

標準概述:	夾彎特殊做法
Standard summarise :	Special practice for armhole
執行日期:	2018年7月4日
Term of expiration date:	4-Jul-18
跟進人員:	紙樣組/辦房車間/大貨技術員
Follow-up staffs:	Pattern/Workshop/Technician
標準說明:	
Standard explanation :	<p>見下圖夾彎有花波不折止口拉三針的做法,完成不要挑單針筊夾彎綫.</p> <p>Lace at armhole with 3ZZ with seam allowance unfolded, do not snap off single thread on armhole</p>  <p>此處單針綫完成不可挑掉</p> <p>Do not snap off single thread</p>
備注說明 Remarks:	<p>夾彎單針綫針數要用3CM12針做.</p> <p>Stitch: 12 stitches per 3CM</p>

標準概述:	肩帶面布綑完成要車折的標準
Standard summarise :	Standard of sewing pleat for strap fabric binding
執行日期:	2016年8月1日
Term of expiration date:	1-Aug-16
跟進人員:	紙樣組/辦房車間/工藝組
Follow-up staffs:	
標準說明:	
Standard explanation :	<p>前肩帶是兩層面布,面布要比丈根大的,完成要有縮鄒的款式,統一做工字折給客批板(每組總指有給一個標準做法的附片)(除客人特別要求除外)</p> <p>2 layer fabric on front shoulder strap, fabric is bigger than elastic, and finish with shrinkage, unify that do box-pleat to guest for approval sample. Except for special requirement (Every general instructor keeps a standard mock-up)</p>
圖1. 款式圖 Style sketch	
圖2. 統一此類款式做工字折給客批板(每組總指有給一個標準做法的附片)(除客人特別要求除外) Do box-pleat to guest for approval sample. Except for special requirement (Every general instructor keeps a standard mock-up)	
備注說明 Remarks:	

HopLun Technical standard direction

標準概述:	连体款下腳位落定型紗不可容紗車
Standard summarise :	Can't shrink fixed net at underbust with fixex net to sew for siamese style
執行日期:	2018年3月22日
Term of expiration date:	22-Mar-18
跟進人員:	用量组/辦房車間/大货技术员
Follow-up staffs:	

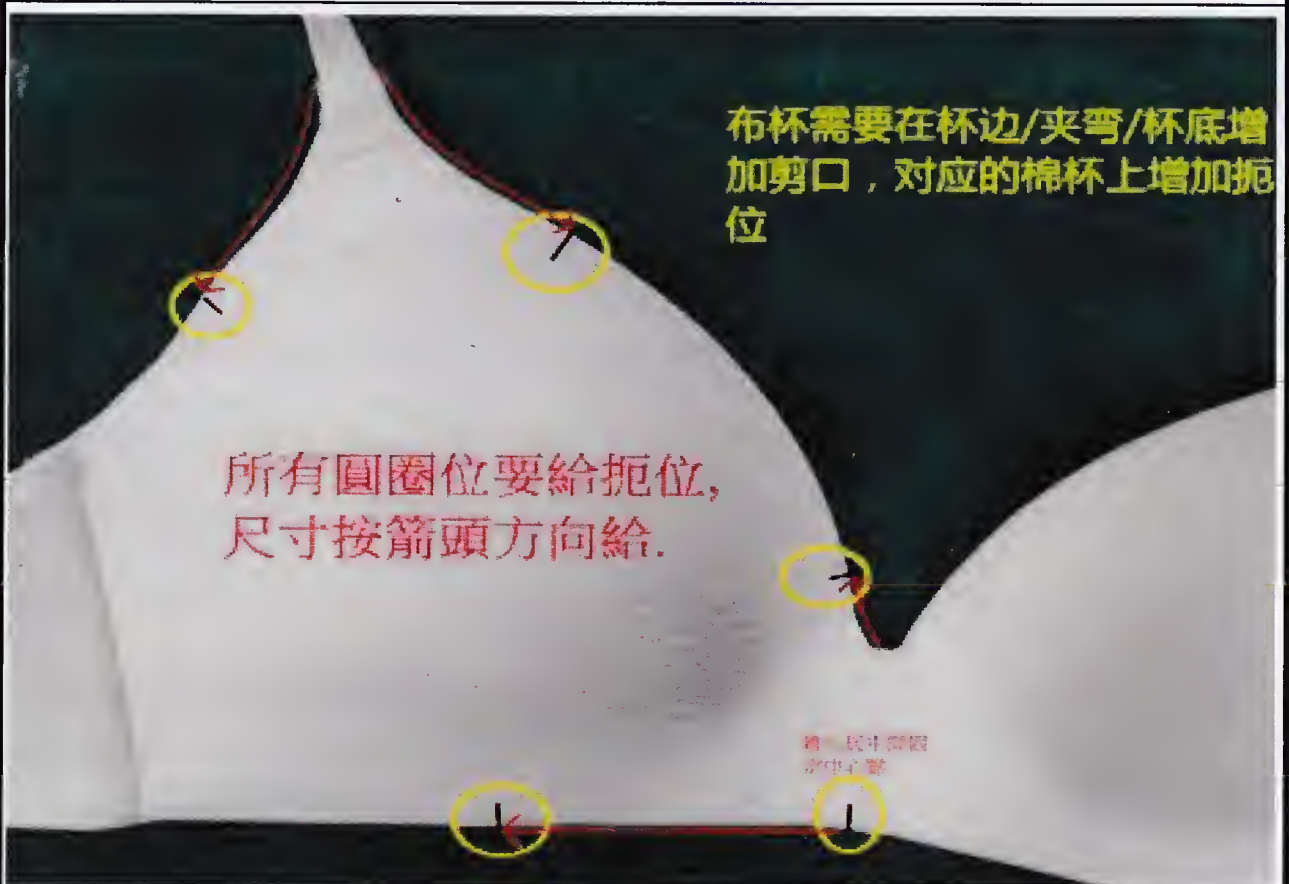
標準說明:

Standard explanation :

案例056-T-00066B款连体款下腳位落定型紗,做板時有時候容紗車,有時候沒有容紗車.導致試身時效果不一樣.

統一此种款式車間落紗的時候要按正常做,不可容紗車.

056-T-00066B: attach fixed net at underbust, sometimes shrink to sew, sometimes not shrink to sew, caused different fitting effect. Unify that can't shrink to sew the fixed net.


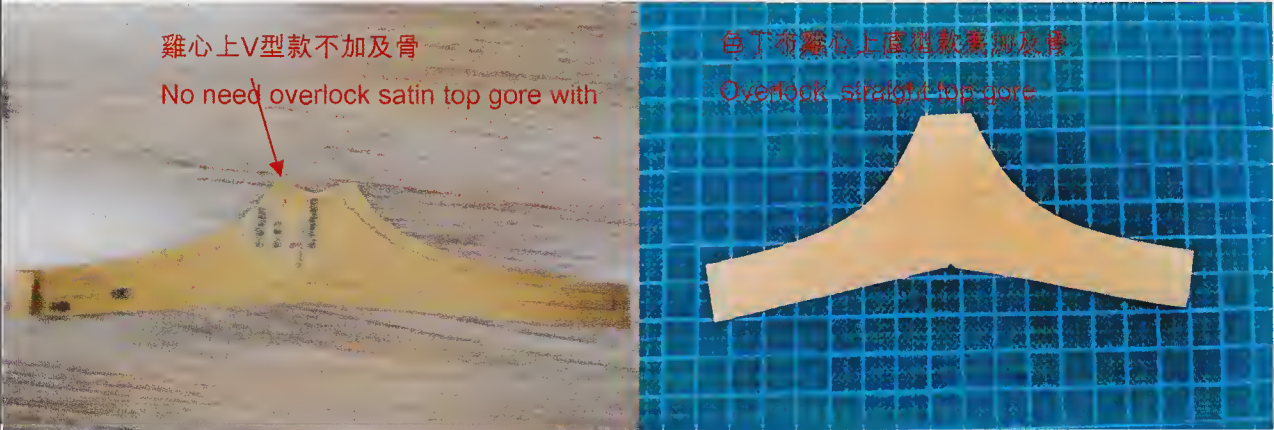


備注說明 Remarks:



合隆技術標準指引

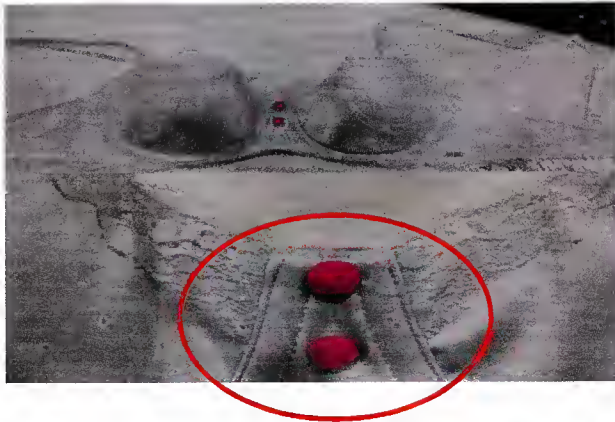
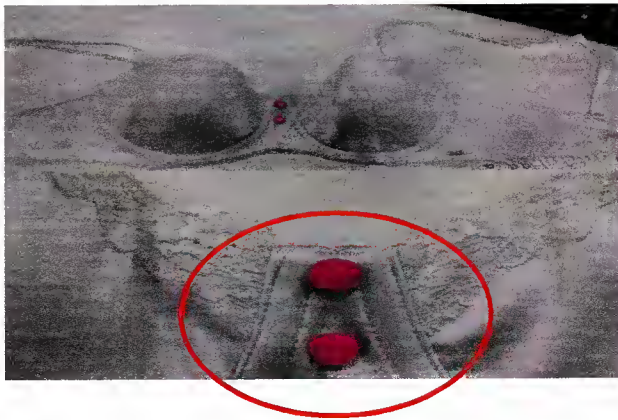
HopLun Technical standard direction

標準概述:	色丁布雞心咀工藝做法
Standard summarise :	Sewing of satin top gore
執行日期:	2018年5月9日
Term of expiration date:	9-May-18
跟進人員:	紙樣組/辦房車間/大貨技術員/工艺员
Follow-up staffs:	Pattern/Workshop/Technician/Craft
標準說明:	
Standard explanation :	
統一色丁布雞心上V型的款式不用及骨,直型的要加及骨.	
No need overlock satin top gore with V-shape.But straight must overlock	
 <p>色丁布雞心上V型款式 satin top gore with V-shape</p>	
 <p>雞心上V型款不加及骨 No need overlock satin top gore with</p> <p>色丁布雞心上直型款式要加及骨 Overlock straight top gore</p>	
備注說明 Remarks:	
註:完成雞心頂上尺寸不計鋼圈套2MM之內的不用加及骨.	
No need overlock when the size of top gore within 2MM (excl.wirecasing)	



合隆技術標準指引

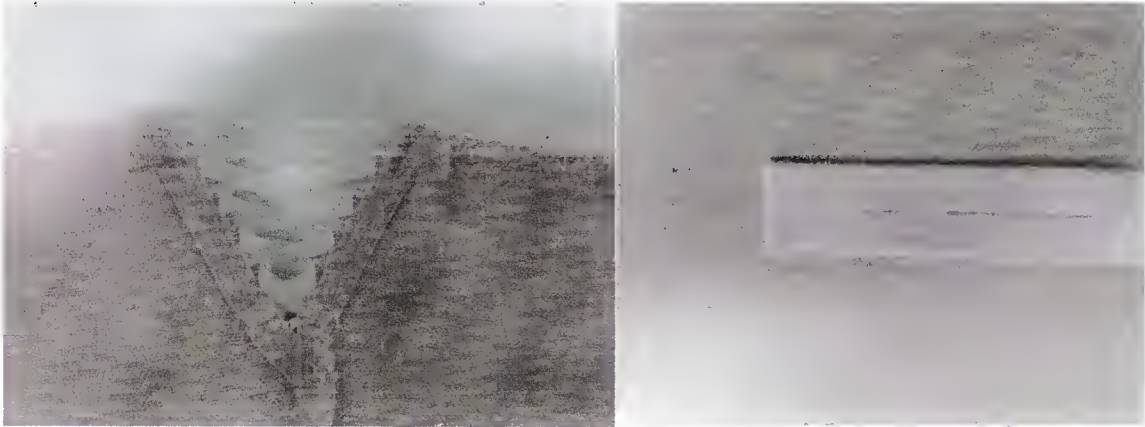
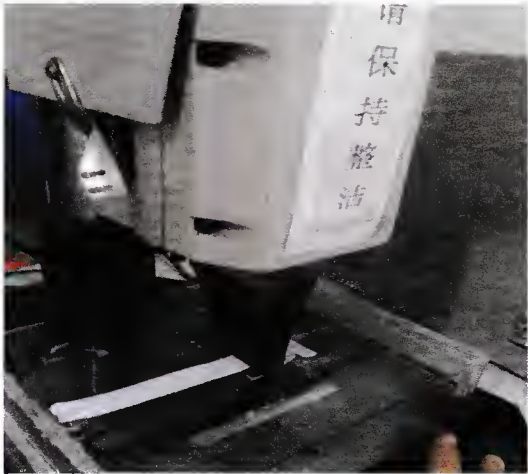
HopLun Technical standard direction

標準概述:	順摺碗款式雞心頂做法
Standard summarise :	Method of top gore
執行日期:	2017年7月12日
Term of expiration date:	12-Jul-17
跟進人員:	辦房車間/大貨技术员
Follow-up staffs:	
標準說明:	
Standard explanation :	<p>所有順摺碗款式,統一以下2點</p> <p>Unify below standard for all styles with seam allowance towards underbus</p> <p>1. 雞心頂做不襟線.(註:板車間特別留意,如遇特殊情況不襟線不方便做下工序的請提出,視情況決定是否增加襟線工序.)</p> <p>No topstitch on top gore (workshop should propose out if inconvenient for no topstitch and whether increase topstitch depend on actual situation)</p> <p>2. 雞心頂不可加紗 Can't attach fixed net</p>
圖1. 款式圖 Sketch1. Style sketch	
圖2. 雞心完成效果 Sketch2. Gore completion effect	
備注說明 Remarks:	



合隆技術標準指引



HopLun Technical standard direction

標準概述:	絲帶織帶料要用超聲波切
Standard summarise :	Cut ribbon or woven strap with ultrasonic
執行日期:	2016年7月1日
Term of expiration date:	1-Jul-16
跟進人員:	紙樣組/辦房車間/工藝組
Follow-up staffs:	Pattern Team/Workshop in sample room/Technology tea
標準說明:	
Standard explanation :	
物料是絲帶或織帶或散絲部位的款式(見圖1),統一用超聲波切.(見圖2) For ribbon or woven strap or filoselle, unify to cut with ultrasonic.	
圖1. 款式圖 Style sketch	
圖2. 超聲波機切 Cut with ultrasonic	
備注說明 Remarks:	



合隆技術標準指引


HopLun Technical standard direction

標準概述:	鎖勾圈
Standard summarise :	Lock H&E
執行日期:	2016年4月1日
Term of expiration date:	1-Apr-16
跟進人員:	紙樣組/辦房車間/工藝組
Follow-up staffs:	Pattern Team/Workshop in sample room/Technology tea
標準說明:	
Standard explanation :	
所有要車勾圈的款.(見圖1),統一兩側做墜針密鎖.(見圖2) For all style with H&E, drop stitch to densely lock both edge.	
圖1. 款式圖 Style sketch	
圖2.統一兩側要做墜針密鎖 drop stitch to densely lock both edge.	
備注說明 Remarks:	

HopLun Technical standard direction

標準概述:	特別款在做板時要考慮方便生產的做法
Standard summarise :	Consider convenient way for production for special sample
執行日期:	2017年3月15日
Term of expiration date:	15-Mar-17
跟進人員:	紙樣組/辦房車間/工藝組
Follow-up staffs:	Pattern Team/Workshop in sample room/Technology tea

標準說明:
Standard explanation :
<p>以448-S-00332A款舉例(見圖1),統一特別款在做板時要考慮方便生產的做法.</p> <p>Take 448-S-00332A for example, should consider the convenient way for production when doing sample</p>

圖1. 款式圖


備注說明 Remarks:
<p>案例448-S-00332A款,此款上杯是網布.下杯是泳衣布,板杯橫骨做的開骨.此种布料之前有統一要做襟骨.再次提醒.</p> <p>Remind that as 448-S-00332A, it's a special style that mesh on upper cup, swim fabric on bottom cup with horizontal seam. This fabric unified to topstitch before</p>



合隆技術標準指引

HopLun Technical standard direction

標準概述:	网布孔大的料要加及骨布边散口
Standard summarise :	OL fabric raw edge of mesh with big hole
執行日期:	2018年7月4日
Term of expiration date:	4-Jul-18
跟進人員:	跟單組/紙樣組/辦房車間/大貨技術員
Follow-up staffs:	Merchandising/Pattern/Workshop/Technician
標準說明:	
Standard explanation :	
网布孔大於3MM的料要加及骨布边散口后再做下一个工序. OL fabric raw edge of mesh with big hole more than 3MM	
	
備注說明 Remarks:	
案例:505-AA-00146款,此款腰头拉三针落丈根,因主布网孔太大,导致完成后腰头子口大小,高低不平.Take 505-AA-00146 for example,3 ZZ attach elastic at waist mesh with big hole cause back waist seam allowance uneven,	



5、工藝做法類 Process Standard

5-2、工藝類 Process standard

合隆技術標準指引

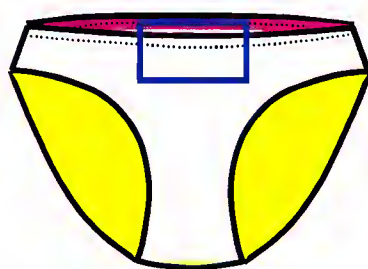
HopLun Technical standard direction



標準概述: STANDARD BRIEF:	6mm丈巾的車種配搭要求 How to sew 6mm elastic
執行日期: EXCUTION DATE:	2011年11月3日 3-Nov-11
跟進人員: FOLLOW-UP STAFFS:	辦房車間/技術員 Sample workshop/ Technician

標準說明STANDARD EXPLANATION:







褲頭,褲比無花芽丈巾的為6mm,以下為丈巾車法:

Elastic without picot width at waist&leg opening is 6mm,pls adopt the standard sewing method:



-  里布 Lining
-  6mm無花芽丈巾 6mm elastic without picot
-  三針車 3-step zag zig
-  人字車 Zag zig

1. 拉6mm無花芽丈巾的標準車法Standard sewing method of attaching 6mm elastic without picot:

車法Sewing Method		工序Sewing Process	
首選 First choice:	先三線級骨,后入字襟丈巾 First,3th o/l neaten cup edge and elastic;then Z/z attach elastic on waist	 1.1.三線級骨落丈巾 3th o/l neaten cup edge and elastic	 1.2.入字襟丈巾 Z/z attach elastic
次選 Second choice:	人字先拉丈巾,人字再復襟 First,Z/z attach elastic on waist;then Z/z Topstitch elastic on waist again	 2.1.人字落丈巾 Z/z attach elastic	 2.2.人字復襟丈巾 Z/z Topstitch elastic again
后選 Last choice:	人字先拉丈巾,三針再襟丈巾 First,Z/z attach elastic on waist;then 3-step Z/z topstitch elastic on waist	 3.1.人字落丈巾 Z/z attach elastic	 3.2.三針襟丈巾 3-step Z/z topstitch elastic

2. 如果客戶提出用三針直接拉6mm丈巾,應當拒絕並建議客戶采用其他車法代替.

.If customer suggests to use 3-step z/z directly topstitch 6mm elastic,pls refuse this suggestion gently and suggest to use another sewing methods.

備注說明Remarks:

如果丈巾有花芽,請勿采用首選方法,請考慮次選和最選這兩種正確車法.

If elastic with picot,pls consider the following two choices:the second and last choices instead of first choice.

合隆技術標準指引

HopLun Technical standard direction

標準概述:	正確統一使用布料的面層
STANDARD BRIEF:	Correctly Uniform Use Of Fabric Layer
執行日期:	2011年6月20日
EXCUTION DATE:	20-Jun-11
跟進人員:	車間總指
FOLLOW-UP STAFFS:	Sewing Team Leader

標準說明STANDARD EXPLANATION:

同一組同一款式的布料, 應使用統一布料的面層.

Pls use uniform fabric layer for fabric of the same style in the same group.

款式圖例 Picture of style:

- 1 2 3 4 部位是相同的布料, 應使用統一的面層.
 1,2,3,4 are all the same fabric, should use uniform shell layer.



3 部位的布料底層向外是錯的。
 Fabric's bottom layer outward at part 3 is wrong.



備注說明Remarks:



合隆技術標準指引

HopLun Technical standard direction

標準概述:	企車摺邊企車法后增加成品燙貨工序.
STANDARD BRIEF:	Iron Seam Allowance Is Necessary For Finished After C/S Fold & Sew Seam Allowance.
執行日期:	2011年6月20日
EXCUTION DATE:	20-Jun-11
跟進人員:	車間總指導/工藝員
FOLLOW-UP STAFFS:	Sewing Team Leader / Carft

標準說明STANDARD EXPLANATION:

需用到企車摺邊企車法的款式(短袖/背心等...), 完成摺邊后需增加成品燙整工序.

Those style need c/s to fold & sew seam allowance,need to iron seam allowance after finished

1. 款式圖例 Example style:



2. 車縫完成后需增加成品燙貨工序

.Need to add iron operation when finished the sewing.



備注說明Remarks:

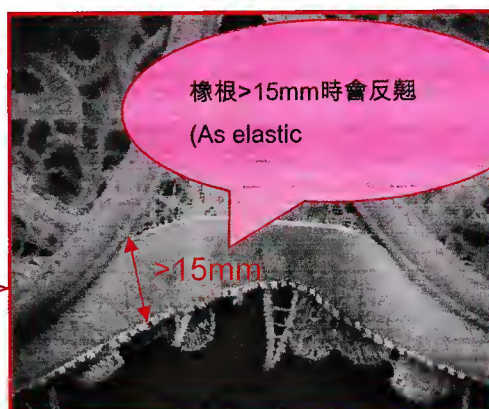
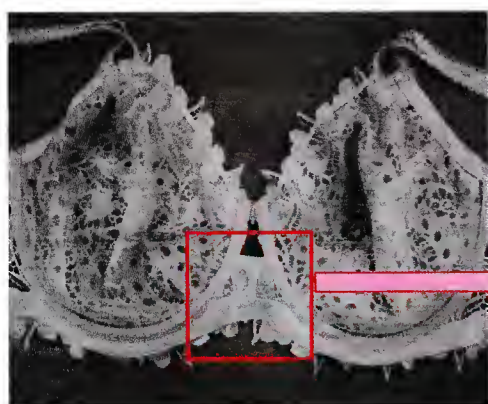
泳衣背心款除外.

ex. the vests of swimsuit .

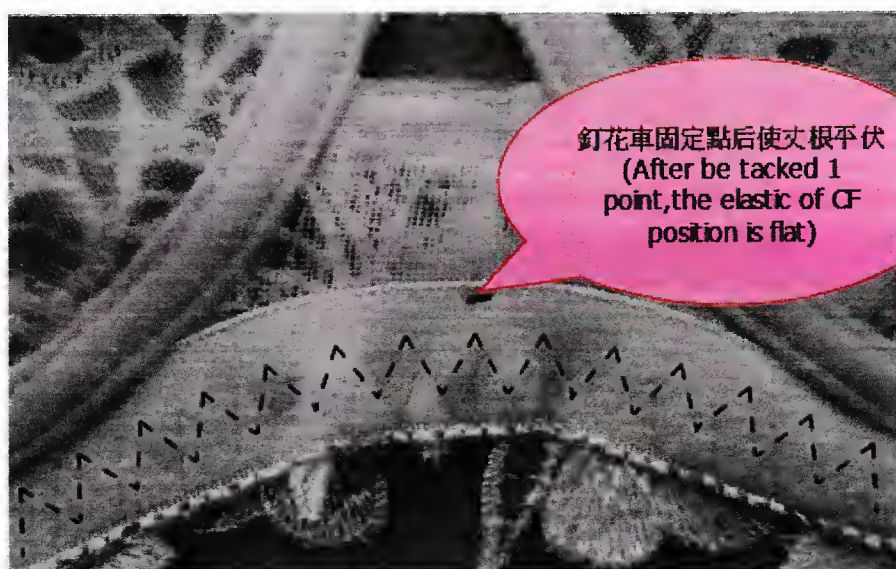
標準概述:	圍款三針車拉下腳大丈巾的做法
STANDARD BRIEF:	How To Attach Wide Elastic At Underbust For Bras By 3-step ZZ L/S?
執行日期:	2011年1月21日
EXCUTION DATE:	21-Jan-11
跟進人員:	車間總指
FOLLOW-UP STAFFS:	Sewing Line Leader

標準說明STANDARD EXPLANATION:

圍款下腳丈根縮率/封度較大而且是使用三針車時.統一在雞心位丈根邊加釘一點改善丈根反翹的問題.
 .When we using wide elastic while using 3-step zz l/s attach elastic of a bra, the CF position had to be tacked 1 points with bow attaching machine to avoid the elastic warping .



現統一在雞心位丈根邊使用釘花車加釘一點可以改善丈根反翹起拱的問題,如下圖:
 Now ,the CF position had to be tacked 1 points with bow attaching machine to avoid the elastic warping .As the following picture show:

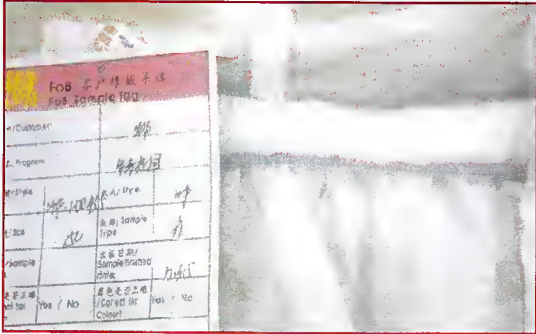


備注說明Remarks:



合隆技術標準指引

HopLun Technical standard direction

標準概述: STANDARD BRIEF:	雙層細條內加活動丈根,細條有縮率或單層出捆條上下用丈根線縮折的做法。 The Method Of Adding Removable Elastic At Inside Of Double Layer Binding, Binding Have Minification Or Binding Is Single Layer And Top And Btm Of Binding Are Shirred Using Elastic Thread.
執行日期: EXCUTION DATE:	2012年4月19日 19-Apr-12
跟進人員: FOLLOW-UP STAFFS:	紙樣組長/辦房車間/工藝組 Pattern Team/Workshop/Technical Team
標準說明STANDARD EXPLANATION:	
<p>雙層細條內加活動丈根,細條有縮率或單層出捆條上下用丈根線縮折的做法,此款式或其類似款式統一用褲頭坎車一次性完成(如下圖所示)。</p> <p>Removable elastic at inside of double layer binding, binding have minification or binding is single layer and top and btm of binding are shirred using elastic thread, for this style or like this style, pls use c/s to sew waist directly and only for one time(eg.as picture below).</p> <div><div>款式圖:</div><div></div></div> <div><div>使用企車一次性完成縮折</div><div></div><div></div><div><div>成后效果圖例</div><div></div></div></div>	
備注說明Remarks:	



合隆技術標準指引

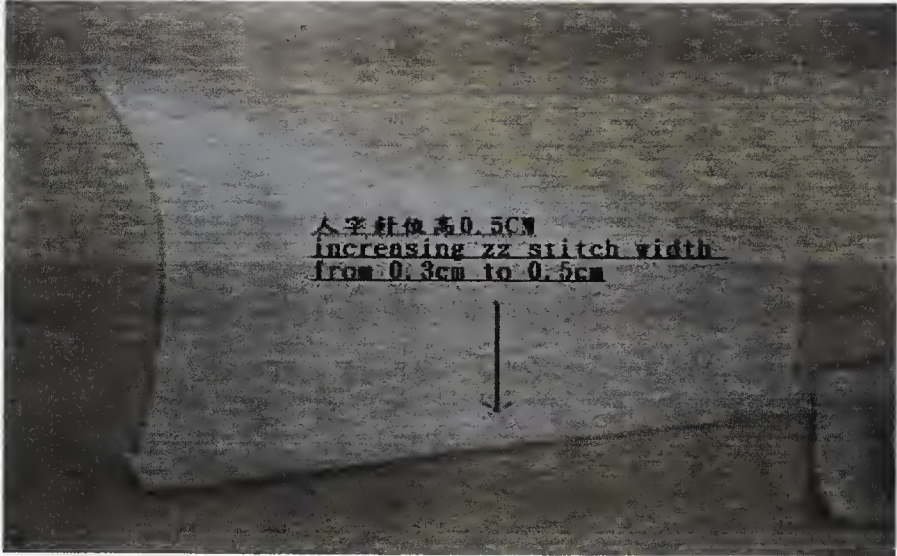
HopLun Technical standard direction

標準概述:	調整隱型比款人字針位
STANDARD BRIEF:	Adjust The Style That ZZ Stitch(For Attaching Elastic To Wing) Be Invisible Outside And Without Topstitch Operation.
執行日期:	2012年4月19日
EXCUTION DATE:	19-Apr-12
跟進人員:	紙樣組長/辦房車間/工藝組
FOLLOW-UP STAFFS:	Pattern Team/Workshop/Technical Team

標準說明STANDARD EXPLANATION:

隱形比款人字拉丈根無需襟線的款式.統一將人字針位調高至0.5CM.完成外觀更平服(只限原料).

For the style that zz stitch(for attaching elastic to wing) be invisible outside and without topstitch operation,adjust zz stitch to 0.5cm which can help make appearance look more flat and even.



針高0.5cm限厚丈根厚料(薄料拉后會卷)

備注說明Remarks:

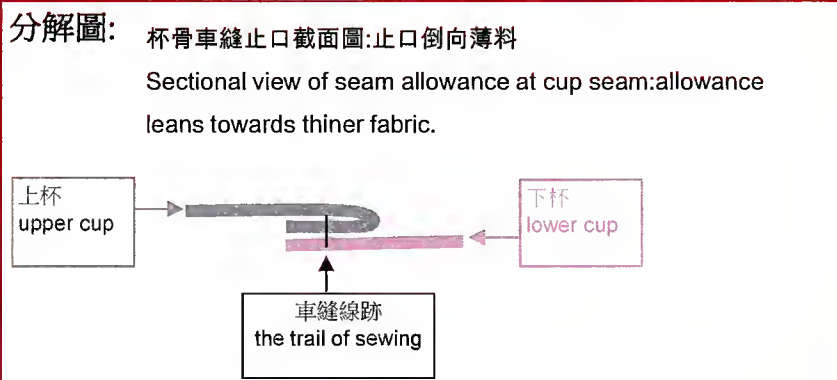
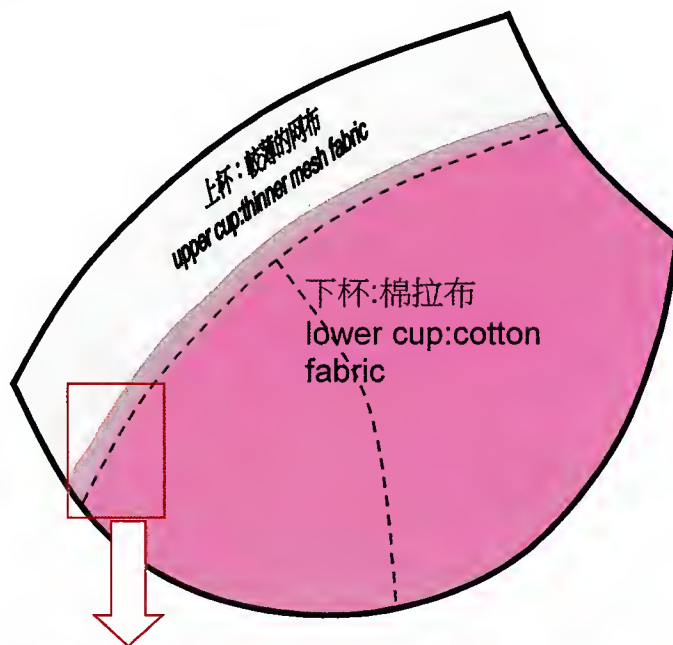
合隆技術標準指引

HopLun Technical standard direction

標準概述:	杯骨不襟線的止口倒向要求
STANDARD BRIEF:	Rqst Of The Leaning of Allowance Of Cup Seam Without Sewing Line
執行日期:	2011年4月6日
EXCUTION DATE:	6-Apr-11
跟進人員:	車間總指/紙樣組長
FOLLOW-UP STAFFS:	Sewing Line Leader/Pattern Team Leader

標準說明STANDARD EXPLANATION:

- 1) 杯骨位, 如果客人沒有特殊要求的, 需加襟線工序.
point of cup seam, if buyer have not request, we need to add the sewing on line.
- 2) 較薄的布料与較厚的布料拼合車縫時, 杯骨上不壓線的款式, 止口倒向應順向薄料. 如下圖所示:
When joining thin fabric and thick fabric without sewing one line on it ,pls make sure the seam allowance lean to the thinner side if the style have on line on cup seam. Such as the picture below:



備注說明Remarks:

透視料的做法需征求技術員意見後再決定.



合隆技術標準指引

HopLun Technical standard direction

標準概述:	所有客下腳/腰頭/褲比都提供(最小)拉度尺寸. Provide extention size of underbust/waist and legopening for all customers
STANDARD BRIEF:	
執行日期:	2015年3月26日
EXCUTION DATE:	26-Mar-15
跟進人員:	紙樣組長/車間
FOLLOW-UP STAFFS:	Paper pattern/ Sewing room
標準說明STANDARD EXPLANATION:	
<p>BD提出問題,針對087,448,199,187,033,466,074,200,293客是沒有拉度尺寸 , 討論能否根據物料或款式給拉度尺寸。</p> <p>For 087,448,199,187,033,466,074,200,293 Customers, BD raised a question that the styles have no stretch size, discussing whether we can give a extention size according to fabrics or styles.</p>	
備注說明Remarks:	
<p>統一所有客下腳/腰頭/褲比都提供(最小)拉度尺寸.</p> <p>Uniformly provide (smallest) extention size of underbust/waist and leg opening for all</p>	



合隆技術標準指引

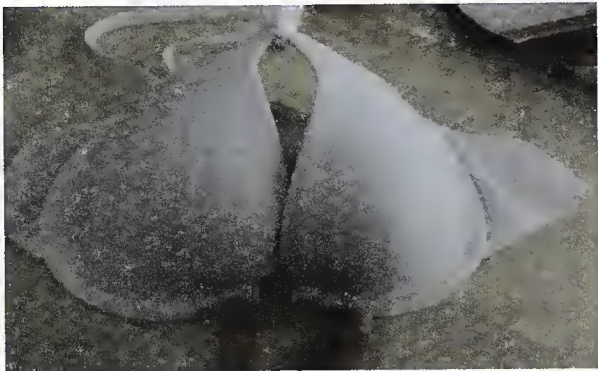
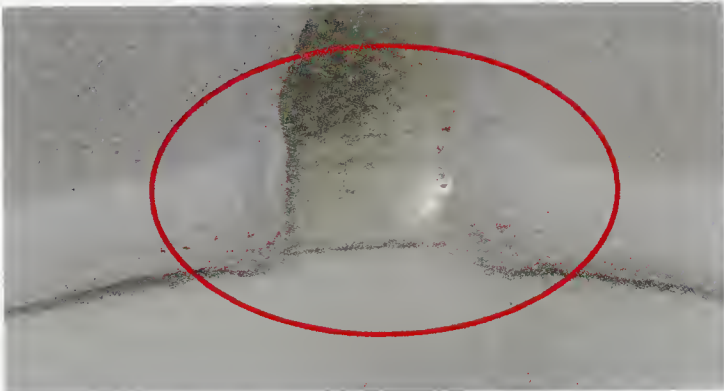
HopLun Technical standard direction

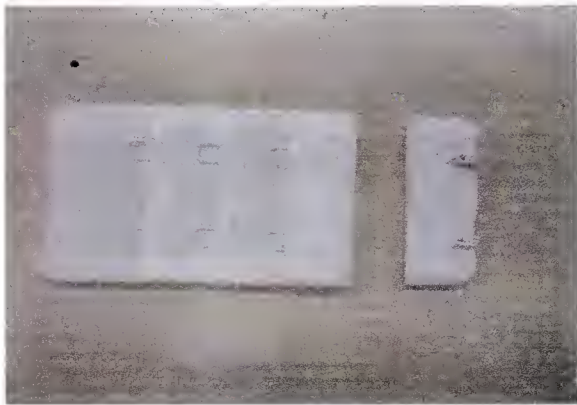
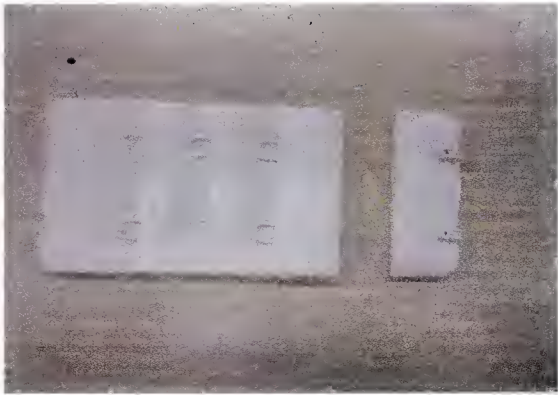
標準概述:	統一里布分正反面
STANDARD BRIEF:	Unify for lining fabric with positive and negative
執行日期:	2013年10月22日
EXCUTION DATE:	22-Oct-13
跟進人員:	紙樣組長/紙樣技術員/辦房車間
FOLLOW-UP STAFFS:	Paper pattern/Technician/Product line in sample room
標準說明STANDARD EXPLANATION:	
<p>統一里布分正反面：除平紋布,啫士布以外，其它客盡量同一組單統一用反面貼肉。</p> <p>Unify lining fabric with positive and negative : unify the negative side to be close the skin at the same program, excluding plain /Gel.</p>	
備注說明Remarks:	
<p>客人有特別要求除外</p> <p>Except for special demand for some customers</p>	

合隆技術標準指引

HopLun Technical standard direction

標準概述:	針對長下扒倒網碗款的做法 Method of long cradle with seam allowance of upper cup towards cup
STANDARD BRIEF:	
執行日期:	2015年3月26日
EXCUTION DATE:	26-Mar-15
跟進人員:	紙樣組長/車間
FOLLOW-UP STAFFS:	Paper pattern/ Sewing room
標準說明STANDARD EXPLANATION:	
<p>針對長下扒倒網碗款。第一次做貨是不撞色的，紙格在碗圈位增加了凸刀口對杯骨及近心位花波。翻單時需要撞色，碗圈位增加的凸刀口完成會外露。討論如何做方便大貨工廠（參考087-L-01162 款）</p> <p>For style that long cradle with seam allowance of upper cup towards cup, it is first time to be not stuck on one color when making production. Sticking-out notch is increased at wire casing on paper pattern, which towards cup seam and lace scallop that are closed to gore. It needs to be stuck on one color while repeating order, but sticking-out notch at wire casing will expose after finsh. Discussing how to do is convenient for bulk production. (Take 087-L-01162 as reference.)</p>	
	
備注說明Remarks:	
<p>類似情況統一限單增加工序修掉凸出多餘子口。 Uniformly confine the order to increase process to cut excessive seam allowance in similar</p>	


標準概述:	不可以單獨用透明膠片做雞心
Standard summarise :	Can't sew gore with transparent rubber band alone
執行日期:	2016年6月29日
Term of expiration date:	29-Jun-16
跟進人員:	紙樣組/辦房車間/工藝組
Follow-up staffs:	Pattern Team/Workshop in sample room/Technology tea
標準說明:	
Standard explanation :	
雞心位連体款式(見圖1),統一不可以單獨用透明膠片車雞心(見圖2) For gore conjoined style, unify that can't sew gore with transparent rubber band alone	
圖1. 款式圖 Style sketch	
圖2.統一不可以單獨用透明膠片做雞心 can't sew gore with transparent rubber band alone	
備注說明 Remarks:	

標準概述:	超聲波切勾圈的要求
Standard summarise :	Requirement of cutting H&E with ultrasonic
執行日期:	2015年6月
Term of expiration date:	1-Jun-15
跟進人員:	紙樣組/辦房車間/工藝組
Follow-up staffs:	Pattern Team/Workshop in sample room/Technology tea
標準說明:	
Standard explanation :	
<p>超聲波切勾圈的款式(見圖1),統一要在肩帶班單獨給手工撕勾圈開口工序.</p> <p>For the style of cutting H&E with ultrasonic, increase a process of tearing H&E opening manually at strap team</p>	
<p>圖1 . 款式圖 超聲波切勾圈的款式</p> <p>The style of cutting H&E with ultrasonic</p> 	
<p>圖2.統一要在肩帶班單獨給手工撕勾圈開口工序</p> <p>Increase a process of tearing H&E opening manually at strap team</p> 	
備注說明 Remarks:	



合隆技術標準指引

HopLun Technical standard direction

標準概述:	車下腳隧道單針線拉度要求
Standard summarise :	Single thread elasticized requirement of underbust with tunnel
執行日期:	2018年9月26日
Term of expiration date:	26-Sep-18
跟進人員:	辦房車間/工藝組/技術員
Follow-up staffs:	Workshop/Technology/Technician
標準說明:	
Standard explanation :	
<p>如下圖車隧道款式等等.....,工藝統一要备注:完成单针线路要有弹力,弹力跟板效果. Style of underbust with tunnel as below, should remark on OPN that single thread should be elasticized, follow the sample</p> <div></div>	
備注說明 Remarks:	



合隆技術標準指引

HopLun Technical standard direction

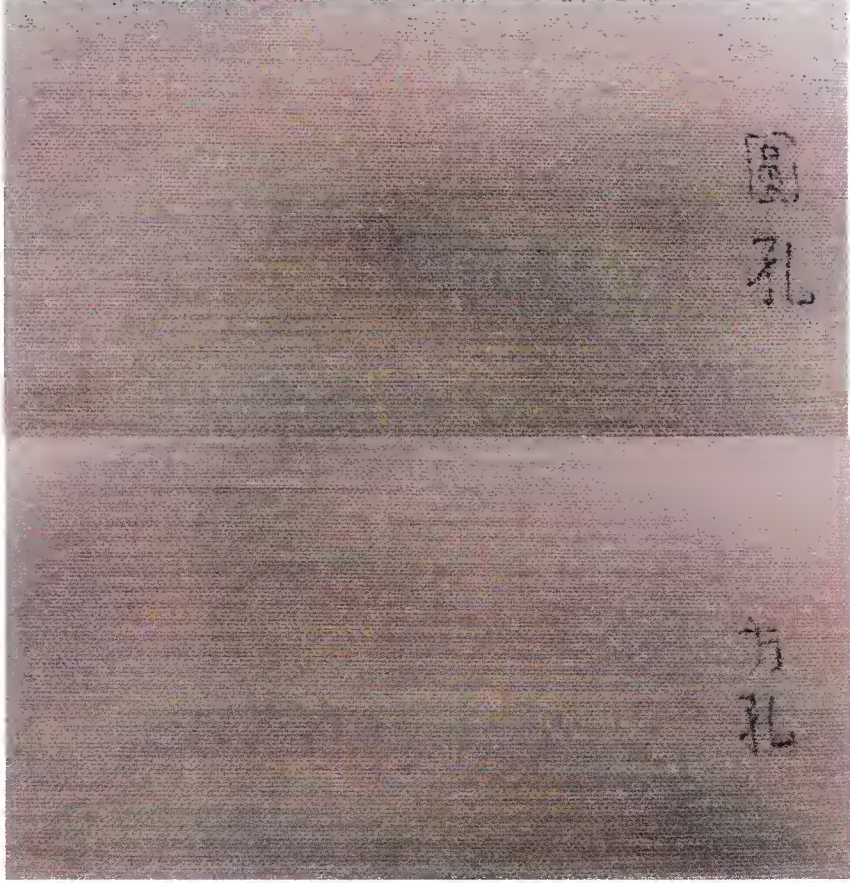
標準概述:	單針鎖鏈車工序描述
Standard summarise :	description of "Single needle lock chainstitch"
執行日期:	2018年5月9日
Term of expiration date:	9-May-18
跟進人員:	工艺员/大货技术员/辦房車間
Follow-up staffs:	Craft/Technician/Workshop
標準說明:	
Standard explanation :	<p>單針鎖鏈与坎車(行單線),完成外觀是一樣的,只是車种不同,因為有的工廠反應沒有單針鎖鏈車.建議工藝統一寫坎車(行單線).工藝統一寫坎車(行單線).</p> <p>Appearance of single needle lock chainstitch and CS with single thread line are the same. Some factories feed back there is no single needle lock chainsititch machine, so advice that CS with single thread line on OPN</p>
備注說明 Remarks:	



合隆技術標準指引

HopLun Technical standard direction

標準概述:	疊㐁蝦蘇款加定單針線工序標準
Standard summarise :	Increase fix s/n stitch
執行日期:	2018年3月22日
Term of expiration date:	22-Mar-18
跟進人員:	用量組/辦房車間/大貨技術員/工藝員
Follow-up staffs:	Unit Consumption/Workshop/Technician/Craft
標準說明:	
Standard explanation :	
疊㐁蝦蘇后,不用車下個工序的款式,統一是否加單針定線工序.	
No need next process after overlapping with CS cover thread on top, unify increase fix s/n stitch	
(1)長度4CM之內加單針工序疊定后再車㐁車蝦蘇.(特殊情況:如客人要求4CM之內也要有彈力,工序改定頭尾兩頭后再車㐁車蝦蘇)	
Increase s/n overlap & fix then CS cover thread on top for less than 4CM length (special:first fix stitch at start and end then CS cover thread on top if guest require elasticity within 4CM length)	
(2)4CM以上的加單針工序定頭尾兩頭后再車㐁車蝦蘇.	
First fix stitch at start and end then CS cover thread on top more than 4CM length	
	
備注說明 Remarks:	

標準概述:	各款式網布的正反面分法的統一.
Standard summarise :	Distinguish right&wrong side of mesh
執行日期:	2018年7月4日
Term of expiration date:	4-Jul-18
跟進人員:	紙樣技術員/大貨技術員/辦房車間
Follow-up staffs:	Technician/Workshop
標準說明:	
Standard explanation :	<p>1:单层裁片做法的,网布圓孔为正面,方孔为贴肉.</p> <p>Round hole is right side and square hole is wrong side for single layer mesh</p> <p>2:做双层部位,面层不是网布的.网布圓孔为正面,方孔为贴肉.Round hole is right side and square hole is wrong side for double layer mesh,but shell fabric is not mesh</p> <p>3:双层网布做运反的做法.网布圓孔为正/反面.</p> <p>Round hole is right&wrong side for double layer mesh with bagged out</p> <p>4:有客人要求的以客人要求做. Follow the guest requirement if there is</p> 
備注說明 Remarks:	



合隆技術標準指引

HopLun Technical standard direction

標準概述:	關於圈8扣與肩帶的結構運用
Standard summarise :	About the structure of ring and shoulder strap
執行日期:	2017年1月1日
Term of expiration date:	1-Jan-17
跟進人員:	紙樣組/辦房車間/工藝組
Follow-up staffs:	Pattern/Workshop/Technology
標準說明:	
Standard explanation :	

1:(見圖1)統一圈8扣與肩帶的結構運用標準

Unify the standard of the structure of ring and shoulder strap

圖1.

關於圈8扣與肩帶的結構運用				
8扣種類	內徑	8扣與肩帶的運用方式	8扣圖示	所搭配的肩帶圖示
光身8扣		8扣上沒有任何邊穿,是個光身8扣,內徑為3MM,主要用於肩帶厚度1.5MM以下的沒有波芽的輕薄肩帶。 另注:此種8扣及肩帶的搭配是公常用的做法。		
		8扣上沒有任何邊穿,是個光身8扣,起到加強活動的作用,此類8扣一般適用於有波芽的肩帶,因為有波芽肩帶上的波芽已大大加強了摩擦阻力,常用光身8扣加大活動以方便調節肩帶的鬆緊,且用光身8扣不會對肩帶上的波芽。 另注:3MM內徑的8扣只適用於1MM厚度左右的輕薄肩帶,肩帶厚度在1.5MM及以上的8扣的內徑要用5MM。		
有芽8扣	3MM	8扣內徑邊有芽,主要起加強摩擦作用,使肩帶扣上後不易滑動,起到基本固定作用,此類8扣一般只適用於沒有花芽的光身肩帶,和用於有芽肩帶會因為肩帶邊緣波芽摩擦阻力加上8扣上的邊穿阻力而造成調節8扣非常困難,且8扣上的芽容易對肩帶上的波芽。 另注:(1)3MM內徑的8扣只適用於1MM厚度左右的輕薄肩帶,肩帶厚度在1.5MM及以上的8扣的內徑要用5MM。 (2):此種有芽8扣,除客人特別要求外,通常不常用。		
光身8扣	5MM	8扣上沒有任何邊穿,但內徑為5MM,主要用於肩帶厚度2MM左右的較厚肩帶或原身有鋼條肩帶,因為肩帶厚度穿過8扣後如果內徑太小是穿不過去的,所以我們在使用8扣時如果肩帶太厚建議選用內徑5MM的8扣,這樣肩帶才能順利的穿過8扣,更生產得以順利進行。		
圈8扣扣種類	寬度(內徑)	圈8扣與肩帶的運用方式	肩帶種類	所搭配的肩帶圖示
圈扣		無波芽的光身肩帶,圈扣內徑要與肩帶寬度一致。	光身丈根	
		普通有波芽的肩帶,在肩帶不記波芽的基礎上,圈扣內徑要與肩帶的寬度一樣大,如果肩帶的波芽太大或太厚就要再加大扣子的內徑寬度(具體加大多少高度要看肩帶芽高低而定)	有芽丈根	
8扣		無波芽的光身肩帶,肩帶寬度要與扣子內的寬度一樣大。	光身丈根	
		有波芽的肩帶,要在肩帶不記波芽的基礎上加大扣子的內寬度1-2MM(具體加大多少要看肩帶芽高低而定);加大扣子的內寬度是避免肩帶太緊,不方便穿扣。	有芽丈根	

備註:跟單留意為保證扣子與丈根匹配的標準,所有扣子要做好第一次板後再定大貨料。(板車間第一次做板時如發現有扣子與丈根不匹配問題要與跟單反饋,跟單要按車間建議跟進)

備註說明 Remarks:

見附頁電子檔明細

Detail as attachment



合隆技術標準指引

HopLun Technical standard direction

標準概述:	合理的放麥頭位置
Standard summarise :	Place label reasonably
執行日期:	2018年7月4日
Term of expiration date:	4-Jul-18
跟進人員:	跟單組/紙樣組/辦房車間/大貨技術員
Follow-up staffs:	Merchandising/Pattern/Workshop/Technician
標準說明:	
Standard explanation :	

例如下圖款式,做辦時麥頭是用的合隆麥代用的,位置在側骨,後來生產大貨時工廠反映大貨麥頭完成會外露出上比.經与客人溝通后改在杯底.

Place substitutive label at side seam when making sample, it will come out from upper wing in bulk production



統一,板房做辦時要根據客戶麥頭大小確定放麥頭的位置,如客人要求的位置不合適,要及時反饋給客人更改位置.(註:特別要注意考慮小碼貨放麥頭是否有問題.)

Confirm label placement according to label's size, feed back to guest to change if the placement not reasonable



備注說明 Remarks:

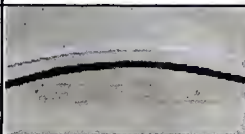
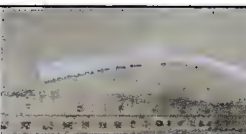
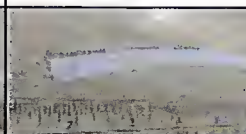

標準概述:	統一鋼圈套開口朝向:
Standard summarise :	Wire casing opening orientation
執行日期:	2017年9月27日
Term of expiration date:	27-Sep-17
跟進人員:	跟單組/辦房車間/大貨技術員
Follow-up staffs:	Merchandising/Workshop/Technician
標準說明:	
Standard explanation :	

統一鋼圈套開口朝向:Unify Wire casing opening orientation as below

1:有客人要求的跟客人要求. Follow requirement if guest require

2:無客人要求的統一跟HM客開口向弧型外(=弧型長的那邊)Opening towards long curve side if no guest requirement

3:具體看下圖明細 Specific as below

各客鋼圈套開口朝向要求				
客戶要求種類	二家要的所有客隨時包鋼圈套開口朝向要求	第一件: 280客是開口向弧型內的(=弧型短的那邊)	第二件: 280客是開口向弧型外的(=弧型長的那邊)	第三件: 還有一種是沒有開口的.
實物圖				
組別	見客技術員	客戶要求明細		
A組	何齊	無	074015/265客是開口向弧型內要求600客	無開口要求
	丁燕	無	330	無
	三惠張國清	無	無開口要求	無開口要求
B組	周蘭	無	無	503/505/463/113 /063
	趙容權	280		
	鄭麗輝	無	445/275	無
	羅修明	無	無開口要求	無
C組	許翠	無	無	199/033/445
	李正芳			
	徐楚		003	
	陳彩容			
D組	陳超榮	無	無	335/070/466/461
	張麗			
	馬克權			
	周華英	無	無	300

經辦6家比鋼圈套要求總結見下面几點:

- 1:280客是開口向弧型內的(=弧型短的那邊).
- 2:其它客有開口的都是開口向弧型外的(=弧型長的那邊)
- 3:沒有開口的不用分方向做弧型就可.
- 4:鋼圈套彈力照二家提供的實物為準.
- 5:使比鋼圈套套前要是直的.

備注說明 Remarks:



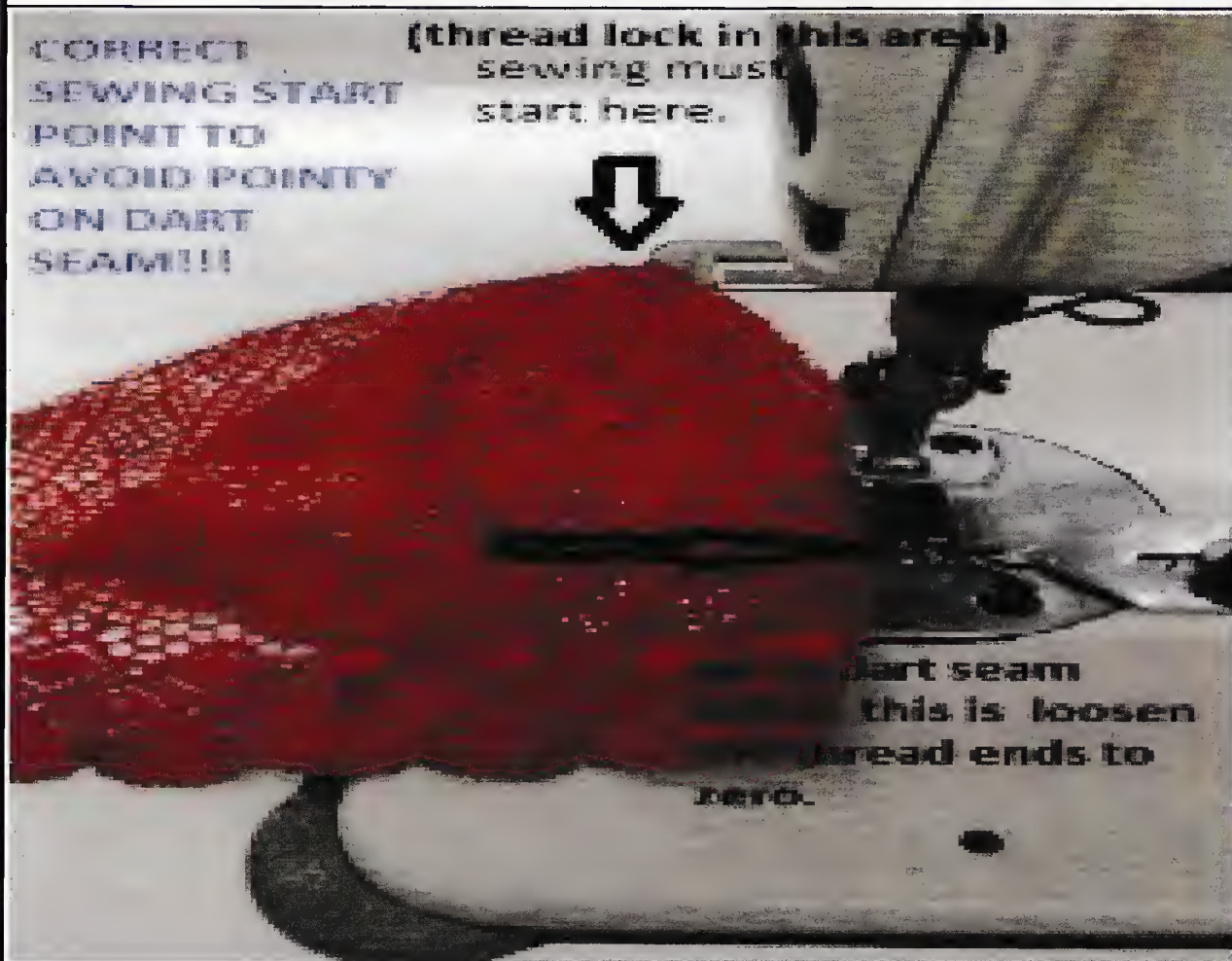
合隆技術標準指引

HopLun Technical standard direction

標準概述:	夾杯折工序描述
Standard summarise :	Description of join cup dart
執行日期:	2018年3月22日
Term of expiration date:	22-Mar-18
跟進人員:	跟單組/用量組/辦房車間/大貨技术员
Follow-up staffs:	Merchandising/Unit Consumption/Workshop/Technician
標準說明:	
Standard explanation :	

統一工藝夾杯折工序,寫上從杯底車向杯尖位夾.(見下圖)

For description of join cup dart, write down" sew from cup bottom to cup dart tip"



備注說明 Remarks:

標準概述:	統一骨位倒向做法
Standard summarise :	Unify seam towards
執行日期:	2016年7月1日
Term of expiration date:	1-Jul-16
跟進人員:	紙樣組/辦房車間/工藝組
Follow-up staffs:	Pattern Team/Workshop in sample room/Technology tea

標準說明: Standard explanation :

肩帶/頸帶/意粉帶(見圖1),所有有骨位的款式骨位倒向統一做法如下:Unify the seam towards of shoulder strap/neck strap/spaghetti as following:

- 1:頸帶位綁帶或肩帶車雙復口的開口統一向夾彎.後比尾級骨運反的綁帶款統一開口向下.(註:綁帶尖位統一跟客人款式圖)Opening of neck strap or strap with CS double edge of binding are folded towards armhole.Opening of back wing tail with OL bagged out downward(tail tip follow design)
- 2:級骨或車運反(完成面不見線的)肩帶或頸帶骨位統一向夾.Seam of strap or neck strap with CS/OL bagged out towards armhole
- 3:統一意粉帶(完成是圓的)不分骨位倒向,完成貼肉就可.(特殊客人要求除外)另:用意粉帶做花仔的,骨位要向正面定到貨上,定好後再打花仔.褲側骨或杯頂要穿意粉帶的開口要向中間.Spaghetti(round after finish) regardless of towards. seam touches body (except special requiremnt). PS: Seam of bow with spaghetti towards right side. Opening of side seam or cup apex with spaghetti towards centre.
- 4:下腳有隧道的款.下腳帶是底/面不見線的,穿下腳帶統一骨位貼肉骨位只口向下.車雙復口的統一開口向上.Seam of underbust with tunnel, sitich invisible on top/bottom towards skin, and seam allowance towards down.Opening of CS double edge of binding are folded upward

圖1. 款式圖

Style sketch




備注說明 Remarks:



合隆技術標準指引

HopLun Technical standard direction

標準概述:	統一剪耳仔位紗工序
Standard summarise :	Cut fixed net inside loop
執行日期:	2017年12月14日
Term of expiration date:	14-Dec-17
跟進人員:	紙樣組/用量組/辦房車間/工藝員/大货技术员
Follow-up staffs:	Pattern/Unit consumption/Workshop/Craft/Technician
標準說明:	
Standard explanation :	
<p>統一杯頂耳仔要穿圈折回耳仔打棗的款.工藝剪耳仔位紗工序放在車間.</p> <p>Loop on cup apex need fold back to bartack with ring inserted, workshop should finish the process of cutting fixed net inside loop</p>	
	
備注說明 Remarks:	



合隆技術標準指引

HopLun Technical standard direction

標準概述:	統一用雙針縮折工序
Standard summarise :	T/N shrink
執行日期:	2018年9月26日
Term of expiration date:	26-Sep-18
跟進人員:	跟單組/紙樣組/辦房車間
Follow-up staffs:	Merchandising/Pattern/Workshop
標準說明:	
Standard explanation :	<p>統一要縮折款式,可以用雙針縮折的就用雙針縮,完成不可外露單針線.例如:下圖款側比止口是1CM,可用3/16針位縮折.....</p> <p>Use T/N shirr as possible for the style need shirr. Stitch invisible after finish. For example: seam allowance at side seam is 3CM, 3/16" t/n shirr is available</p>  
備注說明 Remarks:	

HopLun Technical standard direction

標準概述:	小雞心款雞心腳統一襟線標準
Standard summarise :	Standard of topstitching gore bottom for gore without cradle
執行日期:	2016年7月22日
Term of expiration date:	22-Jul-16
跟進人員:	紙樣組/辦房車間/工藝組
Follow-up staffs:	Pattern Team/Workshop in sample room/Technology tea

標準說明:

Standard explanation :

小雞心款雞心腳要先夾止口後襟線款式(見圖1),統一襟線做法標準(見圖2)

Unify the topstitch standard for gore bottom which need join seam allowance first, then topstitch.

圖1. 款式圖

Style sketch

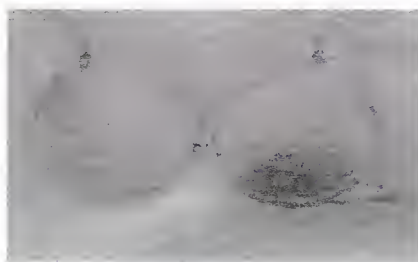


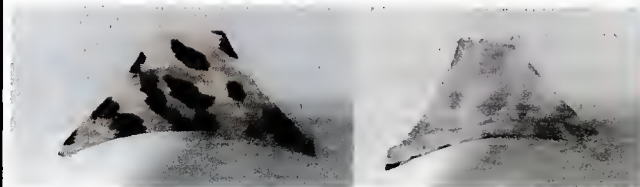
圖2.統一襟線做法標準 Unify the topstitch standard

做法1:完成面不見線,底見線。

做法2:完成底/面見單針襟線。

Practice1:threads invisible at shell, visible at bottom after

Practice2: S/N topstitch visible at shell and bottom



做法1的客戶有以下：

Apply to practice 1 as below:

002, 003, 008, MM, Dorina, Scandale, 600, 063, 071,
074, 015, 362, 339, 056, 441, 168, 470

其他客戶按做法2做貨。

Others apply to practice 2

特殊要求的客戶有:Special customers as below:

463客:至今所有款都是喱士,有花波的,底托雙層紗,底不襟線。

Up to now, all CF are lace with scallop, double layer fixed are under without topstitch

293客：要求做法跟客人原板。Follow guest original sample

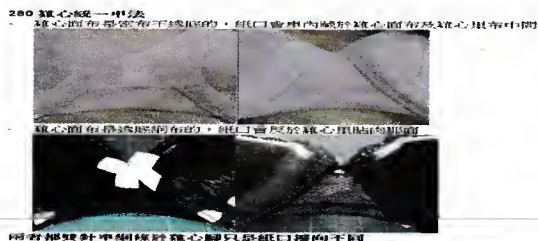
200客:跟設計圖做Follow design drawing

280客:是用雙針托紗襟雞心腳.1:面布是喱士款完成底面見線.2:其它料是完成面不見線底見線.

T/N topsitch fixed net at gore bottom. Thread visible at shell and bottom for lace, and thread invisible at shell, visible at bottom for other fabric.

445客:跟客人做工图要求(普遍是面不见线,鸡心底襟暗线)

Follow guest's workmanship drawing (normally thread invisible at shell, visible at bottom)



備注說明 Remarks:

此標準統計到2016/7/22,後續如有增加或更改的客戶請郵件通知增加或更改標準。(註:經計算雞心腳襟線面見線與面不見線兩種做法工時對比,做面不見線多0.114分 SMV,考慮成本問題還是保留面見線做法)

The standard statistics to 2016/7/22, please email me to update when changing. Compare SMV, thread invisible 0.114minute more than thread visible, so we keep thread visible

標準概述:	小鷄心花波款
Standard summarise :	Lace scallop of small gore
執行日期:	2016年7月4日
Term of expiration date:	4-Jul-16
跟進人員:	辦房車間/工藝組
Follow-up staffs:	Workshop in sample room/Technology team
標準說明:	
Standard explanation :	<p>小鷄心,腳有花波款,花波高5MM及以上的(見圖1),統一在上碗工序增加折回定花邊腳多餘子口描述內容.(見圖2)</p> <p>Small gore with scallop at bottom and the and the scallop height is 5MM or above, unify that increase description of "fold back and fix lace bottom excessive seam allowance" when inserting cup</p>
圖1. 款式圖	
Style sketch	
圖2. 上碗後剪掉花邊腳多餘子口	
Fold back and fix lace bottom excessive seam allowance after inserting cup	 <p>上碗後,尖位只口要折回定線</p>
備注說明 Remarks:	

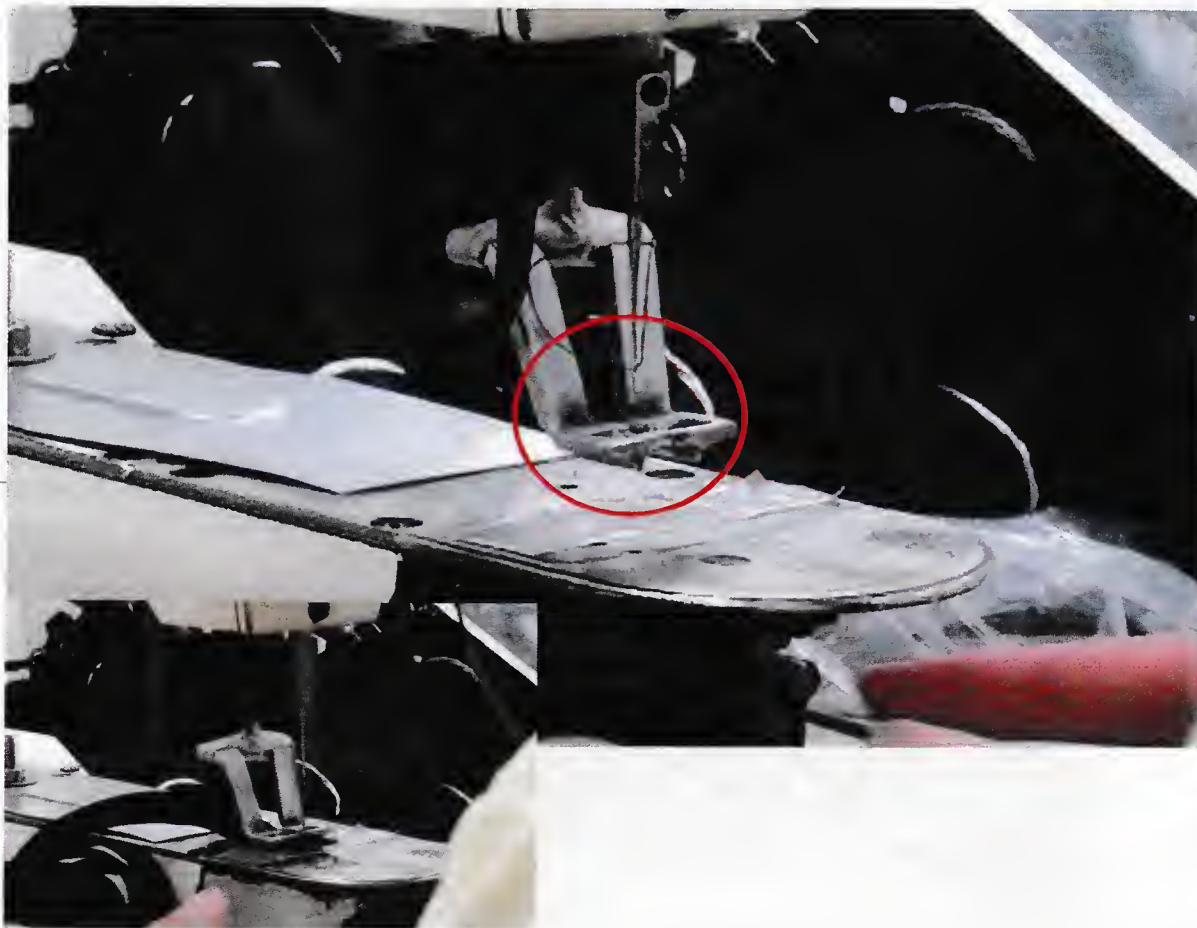
標準概述:	泳衣肩帶打棗定額
Standard summarise :	Quota of swimwear shoulder strap bartack
執行日期:	2017年3月29日
Term of expiration date:	29-Mar-17
跟進人員:	紙樣組/辦房車間/工藝組
Follow-up staffs:	Pattern Team/Workshop in sample room/Technology tea

標準說明:	
Standard explanation :	

因泳衣布料光滑,做肩帶打棗容易錯位,需要在壓腳上加傍位打棗,會比正常打棗慢很多.統一IE分析定額時將SMV從0.12分調整為0.133分.

Smooth swimwear fabric cause dislocation when bartack on shoulder strap. Need add a guide on presser foot to bartack which is slower than normal way. Unify that IE engineer adjust SMV from 0.12minutes to 0.133minutes.

圖1. 實物圖




備注說明 Remarks:



合隆技術標準指引

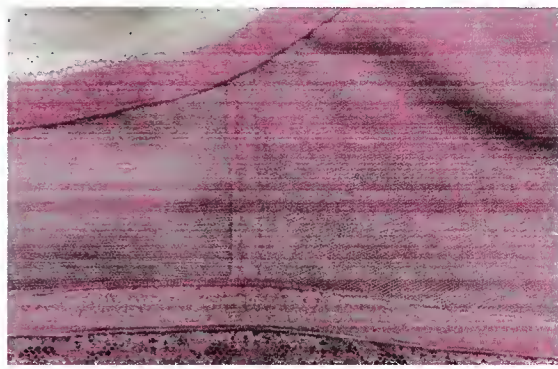
HopLun Technical standard direction

標準概述:	用網條棟比連穿膠骨工藝做法統一
Standard summarise :	Attach binding to side seam with plastic bone inserted
執行日期:	2018年9月26日
Term of expiration date:	26-Sep-18
跟進人員:	工藝員/大貨技術員
Follow-up staffs:	Craft/Technician
標準說明:	
Standard explanation :	
<p>雙針車用網條棟比後要穿膠骨的做法,工藝統一用一道工序完成.</p> <p>For attaching binding to side seam with plastic bone inserted,unify to complete in one process</p>	
	
備注說明 Remarks:	

標準概述:	定型紗&軟紗正反面區分方法
Standard summarise :	Distinguish right&wrong side of fixed net and soft mesh
執行日期:	2018年7月4日
Term of expiration date:	4-Jul-18
跟進人員:	紙樣技術員/大貨技術員/辦房車間
Follow-up staffs:	Technician/Workshop

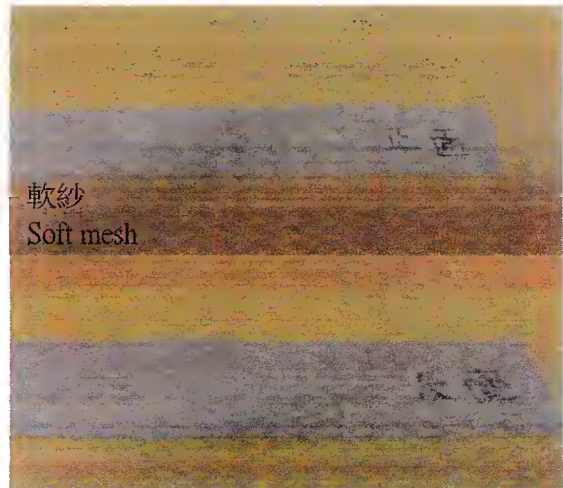
標準說明:
Standard explanation :

例:如下款式等等.....定型紗&軟紗使用正反面區分方法
Distinguish right&wrong side of fixed net and soft mesh as below styles:



統一所有定型紗/軟紗的裁片或捆條.按下面標準區分正反面.
Distinguish right&wrong side of fixed net and soft mesh as below standard

- 1:定型紗平的那边貼肉.Fixed net: flat side close to skin
- 2:軟紗以正面貼肉. Soft mesh: right side close to skin



備注說明 Remarks:




5、工藝做法類 Process Standard

5-3、度法類 Measurement standard



合隆技術標準指引

HopLun Technical standard direction

標準概述:	統一定裝飾鐵牌位置及尺寸度法
Standard summarise :	Fix metal tag and measurement
執行日期:	2017年6月15日
Term of expiration date:	15-Jun-17
跟進人員:	紙樣組/辦房車間/大货技术员
Follow-up staffs:	Pattern/Workshop/Technician
標準說明:	
Standard explanation :	<p>統一定裝飾鐵牌位置及尺寸度法如下:Fix metal tag and measurement as below</p> <p>一:所有裝飾鐵牌定到下比丈根中間.Fix all metal tag in the middle of lower wing elastic</p> <p>二:所有尺寸度法都以下比丈根下邊度.(具體款式度法見下面几點)</p> <p>Measure at bottom of lower wing edge,details as below</p> <p>1:所有駁側骨的款式以駁側骨線為準給距鐵牌位置尺寸.</p> <p>Style of join side seam, offer size from the stitch of join side seam</p> <p>2:小比款式以后比彎下丈根邊尖位度至鐵牌給尺寸.</p> <p>Offer size from back wing curve tip for small wing styles.</p> <p>3:長下扒沒有駁側骨款式,以下扒骨距鐵牌給尺寸.</p> <p>Offer size from cradle seam for long cradle without join side seam styles</p>
見下面款式圖	
備注說明 Remarks:	

標準概述:	後比耳仔度法
Standard summarise :	Measure back loop
執行日期:	2016年7月5日
Term of expiration date:	5-Jul-16
跟進人員:	紙樣組/辦房車間/工藝組
Follow-up staffs:	Pattern Team/Workshop in sample room/Technology tea
標準說明:	
Standard explanation :	

後比位有耳仔的款式(見圖1),統一所有耳仔尺寸都以丈根的中間位度量.(見圖2)
 Unify that measure loop size from the middle of elastic for all back wing with loop

圖1. 款式圖
 Style sketch

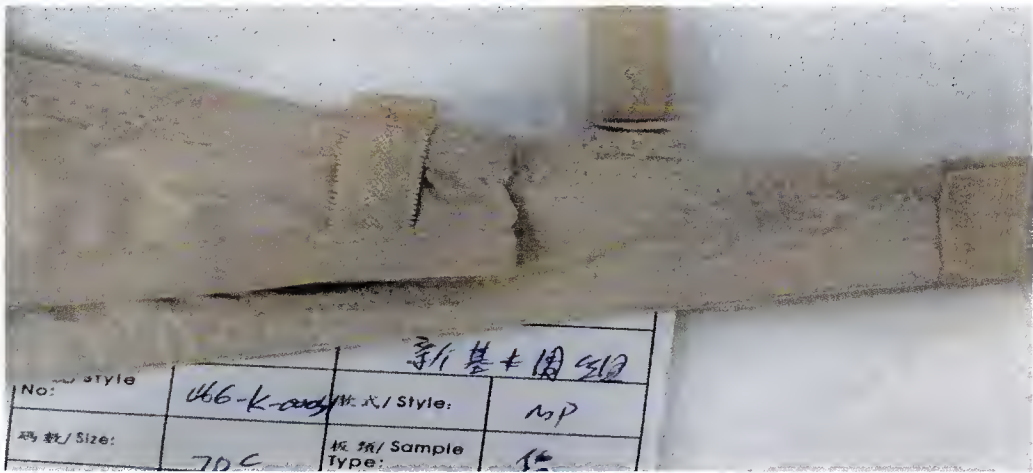
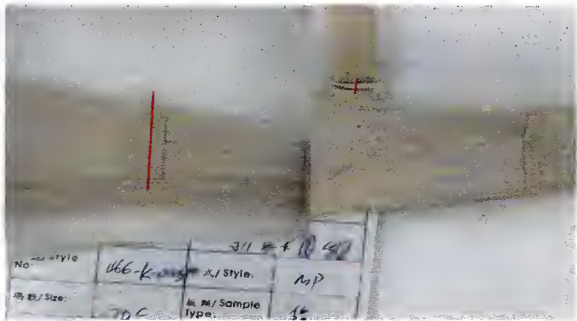


圖2.統一所有後比位耳仔尺寸都以丈跟的中間位度量
 Unify that measure loop size from the middle of elastic for all back wing with loop

所有後比耳仔高,統一度丈根中間(紅色線)位置
 for all back loop height, measure the middle of elastic as red



備注說明 Remarks:



合隆技術標準指引

HopLun Technical standard direction

標準概述:	細碗尺寸度法標準
Standard summarise :	Standard of measuring wire casing
執行日期:	2016年11月10日
Term of expiration date:	10-Nov-16
跟進人員:	紙樣組/辦房車間/工藝組
Follow-up staffs:	Pattern Team/Workshop in sample room/Technology tea
標準說明:	
Standard explanation :	

所有順網/倒網碗款式(見圖1),統一以下內容 : For all styles of seam allowance of upper cup towards front underbust or cup, unify the standard as following:

1. 網碗尺寸雙針外線度. 注明: 客人特殊要求除外. (見圖2)

Measure wire casing along T/N outstitch. Except for guests' special requirements

2. 所有網碗長尺寸只能做正公差. 鋼圈虛位按正常做, 尺寸表要寫正公差. (見圖3)

Only plus tolerance for wire casing size, and plus tolerance should be shown on size chart. Wire play normally

圖1 . 款式圖

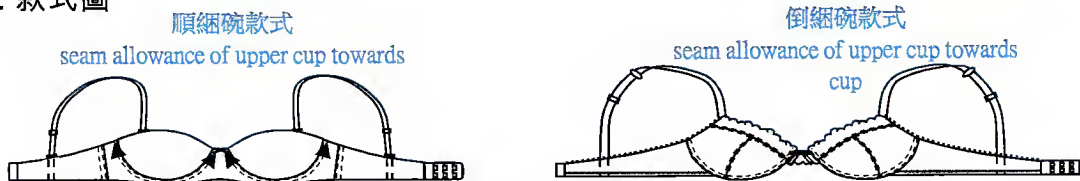
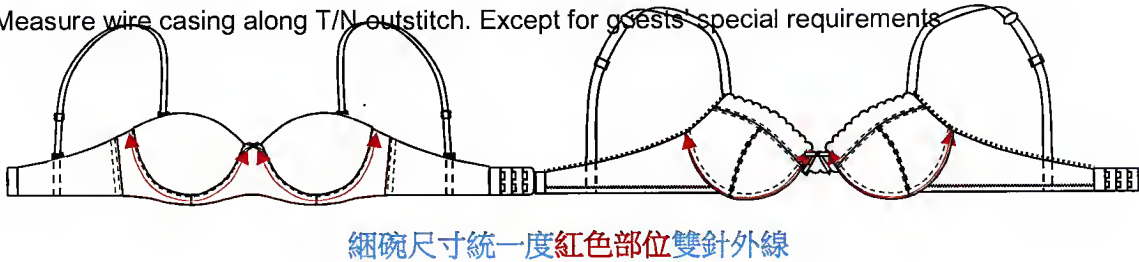


圖2. 統一網碗尺寸雙針外線度. (注明: 客人特殊要求除外)

Measure wire casing along T/N outstitch. Except for guests' special requirements



網碗尺寸統一紅色部位雙針外線

圖2. 統一所有網碗長尺寸只能做正公差. 鋼圈虛位按正常做, 尺寸表要寫正公差. (见下图)

Only plus tolerance for wire casing size, and plus tolerance should be shown on size chart.

He Xun(DG) Technical Development Centre Bra Measurement Table 合隆(東莞)技術部圍尺寸表								
Style No款式號	CBP68R00658	Program組名/款圖圖號55-876組				Factory工廠E		
Position部位	Size尺寸	75A	70B	75B	80B	75C	80C	Unit單位:CM
客方尺寸Customer Measurement								
A Underbust(Flat to 1st head&eye) 下胸圍(平度至第1個頭)		59	55	59	63	59	63	1
B Front neckline length(Incl. wire measure team size) 前邊長(含下包圍圍, 度係線)		16.6	16.6	17.6	18.6	18.6	19.6	0.5
C Cup width(Incl. wire measure in valley) 杯寬(含下包圍圍, 度係線)		16.8	16.8	18.1	19.4	19.4	20.7	0.5
L Wire casing length(along edge, measure in valley) 鋼圈長(沿邊線, 度係線)		17.4	17.4	18.7	20	20	21.3	+ 0.5
M Wing length at curved end(along edge) 比翼長(沿邊線)		9.5	9.5	10	10.5	10.5	11	0.5
N Wire length 鋼圈長		15.9	15.9	17.2	18.5	18.5	19.8	0.2
參考尺寸Reference Measurement								
J Wire play(Incl. butack, push to one side) 鋼圈虛位(含下針測, 推至一邊)		0.5						
Q Strap cut length 釦帶剪長		41.8						

備注說明 Remarks:



6、用量類

Unit consumption standard



合隆技術標準指引

HopLun Technical standard direction

標準概述: 前耳仔尺寸算用量

STANDARD BRIEF: Unit for front loop

執行日期: 2015年6月1日

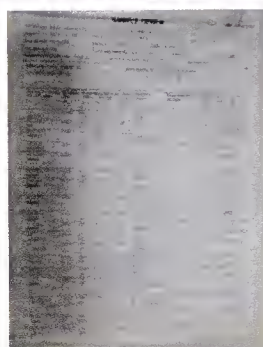
EXCUTION DATE: 1-Jun-15

跟進人員: 用量

FOLLOW-UP STAFFS:

標準說明STANDARD EXPLANATION:

跟單与用量有算前耳仔物料,紙樣沒有給前耳仔尺寸.(此問題用量發現紙樣漏前耳仔尺寸沒有進到位)(案例018-N-00162款).跟單板單漏開後耳仔物料用量有算後耳仔物料.(此問題用量沒有要求跟單更新制單,沒有跟進到位)(案例044-Q-00196款)



備注說明Remarks:

HopLun Technical standard direction

標準概述:	統一包邊款捆出口太寬的用量問題
Standard summarise :	Unit consumption for wide binding
執行日期:	2017年9月6日
Term of expiration date:	6-Sep-17
跟進人員:	跟單組/用量組/辦房車間/大貨技術員
Follow-up staffs:	Merchandising/Unit consumption/Workshop/Technician

標準說明:

Standard explanation :

統一包邊款捆出口太寬的,調車有難度的款,板房車間及機修要提出來,并由總指按客反饋給各組負責對口大貨的技術員,大貨技術員要將需要額外增加用量的款發郵件通知給到營業部大貨跟單定料.增加標準如下:

1-3000件的單額外增加5%的損耗.

3001-10000件的單額外增加3%的損耗.

10000件以上的單按現在營業部加的標準(3.5%)不用再額外增加.

另:大貨技術員還要提前發郵件通知大貨工廠做筒調車.

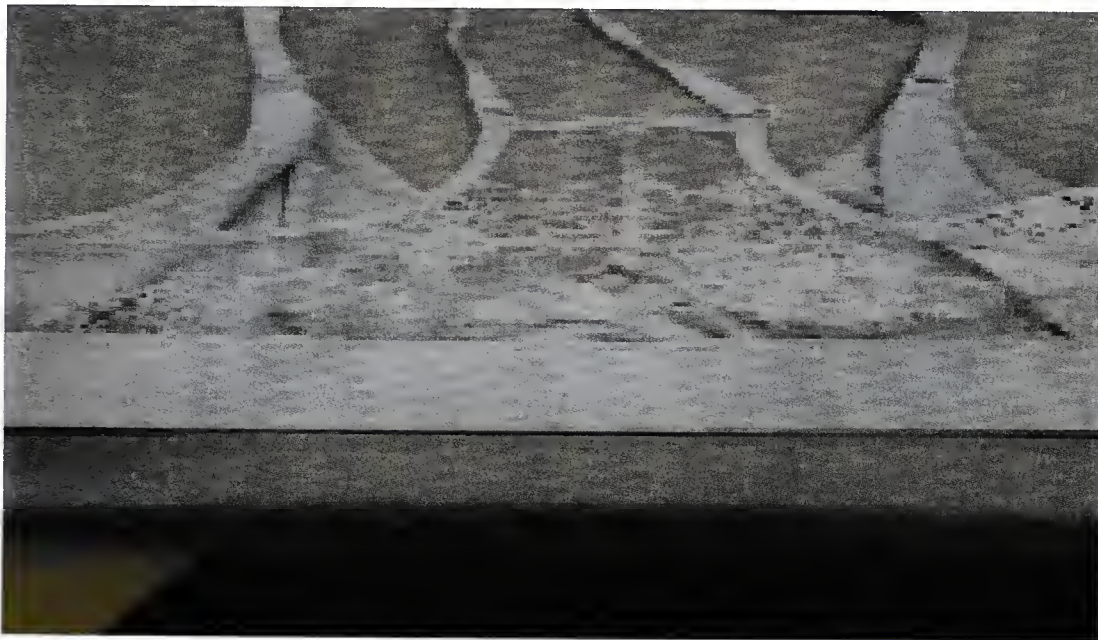
For wrapping style with too wide binding and difficult to adjust sewing machine, sewer and mechanic should propose and line leader should feed back to bulk technician, bulk technician should email to merchandiser to order material, standard as below:

1. Increase 5% wastage for 1~3000 pieces

2. Increase 3% wastage for 3001~10000 pieces

3. Increase 3.5% wastage more than 10000 pieces(according to the standard existed, no need extra

PS: Bulk technician should inform factory to make folder and adjust sewing machine



備注說明 Remarks: